17" & 19" HEAVY-DUTY BANDSAWS

MODEL G0513/G0514

INSTRUCTION MANUAL

G0513 - 17"

G0514 - 19"

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ONLINE MANUAL DISCLAIMER

THE INFORMATION IN THIS MANUAL REPRESENTS THE CONFIGURATION OF THE MACHINE AS IT IS CURRENTLY BEING SHIPPED. THE MACHINE CONFIGURATION CAN CHANGE AS PRODUCT IMPROVEMENTS ARE INCORPORATED. IF YOU OWN AN EARLIER VERSION OF THE MACHINE, THIS MANUAL MAY NOT EXACTLY DEPICT YOUR MACHINE . CONTACT CUSTOMER SERVICE IF YOU HAVE ANY QUESTIONS ABOUT DIFFERENCES. PREVIOUS VERSIONS ARE NOT AVAILABLE ONLINE.

WARNING

Some dust created by power sanding, sawing, grinding, drilling, and other construction activities contains chemicals known to the State of California to cause cancer, birth defects or other reproductive harm. Some examples of these chemicals are:

- Lead from lead-based paints.
- Crystalline silica from bricks, cement, and other masonry products.
- Arsenic and chromium from chemically treated lumber.

Your risk from these exposures varies, depending on how often you do this type of work. To reduce your exposure to these chemicals: work in a well ventilated area, and work with approved safety equipment, such as those dust masks that are specially designed to filter out microscopic particles.

Table Of Contents

1. Safety 2
General Safety Rules....2-3
Additional Rules For Bandsaws 4
2. Introduction 5
3. Circuit Requirements....6
220 Volt Operation 6
110 Volt Operation 7
Grounding 8
4. Machine Features....9
External Features 9
Internal Features 10
5. Set Up 11
Unpacking 11
Piece Inventory 11
Hardware Recognition Chart....12
Clean Up 13
Site Considerations 13
Beginning Assembly 14
Remove Saw Blade 14-15
Table 15
Installing Saw Blade 16
Blade Tracking 17
Positive Stop 18
Dust Collection 19
Fence Assembly 19
Fence Adjustment 20
Table Alignment 20
Start Up 21
Blade Tension 21-22
Fine Tune Tracking 22
Blade Guides 23-25
6. Operations 26
Guide Post 26
Table Tilt 27
Ripping 28
Scale Recalibration 28
Crosscutting 29
Resawing 29-30
Blade Lead 30
Cutting Curves 31
Stacked Cuts 31-32
Blade Speed 32
Blade Selection 33-34
7. Maintenance 35
Schedule 35
Lubrication....36
Wheel Brush 36
Table 36
8. Closure 37
Data Sheet 38-39
Wiring Diagram 40
Parts Diagram/List 41-45
Warranty 46-48

SECTION 1: SAFETY

⚠WARNING

For Your Own Safety Read Instruction Manual Before Operating This Equipment

The purpose of safety symbols is to attract your attention to possible hazardous conditions. This manual uses a series of symbols and signal words which are intended to convey the level of importance of the safety messages. The progression of symbols is described below. Remember that safety messages by themselves do not eliminate danger and are not a substitute for proper accident prevention measures.

⚠DANGER	**Indicates an imminently hazardous situation which, if not avoided, WILL result in death or serious injury.**
⚠WARNING	**Indicates a potentially hazardous situation which, if not avoided, COULD result in death or serious injury.**
⚠CAUTION	**Indicates a potentially hazardous situation which, if not avoided, MAY result in minor or moderate injury, or MAY cause property damage.**
NOTICE	**This symbol is used to alert the user to useful information about proper operation of the equipment.**

⚠WARNING

Safety Instructions For Power Tools

1. **KEEP GUARDS IN PLACE** and in working order.
2. **REMOVE ADJUSTING KEYS AND WRENCHES.** Form habit of checking to see that keys and adjusting wrenches are removed from tool before turning on.
3. **KEEP WORK AREA CLEAN.** Cluttered areas and benches invite accidents.
4. **DO NOT USE IN DANGEROUS ENVIRONMENT.** Do not use power tools in damp or wet locations, or where any flammable or noxious fumes may exist. Keep work area well lighted.
5. **KEEP CHILDREN AND VISITORS AWAY.** All children and visitors should be kept at a safe distance from work area.
6. **MAKE WORKSHOP CHILD PROOF** with padlocks, master switches, or by removing starter keys.
7. **DO NOT FORCE TOOL.** It will do the job better and safer at the rate for which it was designed.
8. **USE RIGHT TOOL.** Do not force tool or attachment to do a job for which it was not designed.

⚠WARNING

Safety Instructions For Power Tools

9. **USE PROPER EXTENSION CORD**. Make sure your extension cord is in good condition. Conductor size must be in accordance with the chart below. The amperage rating is listed on the motor or tool nameplate. An undersized cord will cause a drop in line voltage resulting in loss of power and overheating. Your extension cord must also contain a ground wire and plug pin. Always repair or replace damaged extension cords.

Minimum Gauge for Extension Cords

AMP RATING	LENGTH		
	25ft	**50ft**	**100ft**
0-6	18	16	16
7-10	18	16	14
11-12	16	16	14
13-16	14	12	12
17-20	12	12	10
21-30	10	10	No

10. **WEAR PROPER APPAREL.** Do not wear loose clothing, gloves, neckties, rings, bracelets, or other jewelry which may get caught in moving parts. Non-slip footwear is recommended. Wear protective hair covering to contain long hair.

11. **ALWAYS USE SAFETY GLASSES.** Also use face or dust mask if cutting operation is dusty. Everyday eyeglasses only have impact resistant lenses, they are NOT safety glasses.

12. **SECURE WORK.** Use clamps or a vise to hold work when practical. It is safer than using your hand and frees both hands to operate tool.

13. **NEVER OVERREACH.** Keep proper footing and balance at all times.

14. **MAINTAIN TOOLS WITH CARE.** Keep tools sharp and clean for best and safest performance. Follow instructions for lubricating and changing accessories.

15. **DISCONNECT TOOLS** before servicing and changing accessories, such as blades, bits, cutters, and any other item.

16. **REDUCE THE RISK OF UNINTENTIONAL STARTING.** Make sure switch is in off position before plugging in. Also, the magnetic switch on this machine may start if the switch gets bumped hard enough.

17. **USE RECOMMENDED ACCESSORIES.** Consult the owner's manual for recommended accessories. The use of improper accessories may cause risk of injury.

18. **CHECK DAMAGED PARTS.** Before further use of the tool, a guard or other part that is damaged should be carefully checked to determine that it will operate properly and perform its intended function. Check for alignment of moving parts, binding of moving parts, breakage of parts, mounting, and any other conditions that may affect its operation. A guard or other part that is damaged must be properly repaired or replaced.

19. **NEVER LEAVE TOOL RUNNING UNATTENDED. TURN POWER OFF.** Do not leave tool until it comes to a complete stop.

20. **NEVER USE UNDER THE INFLUENCE** of alcohol or drugs, or when tired.

⚠WARNING

Additional Safety Instructions For Bandsaws

1. **DO NOT OPERATE WITH DULL OR BADLY WORN BLADES.** Dull blades require more effort to use and are difficult to control. Inspect blades before each use.
2. **NEVER POSITION FINGERS OR THUMBS IN LINE WITH THE CUT.** Serious personal injury could occur.
3. **DO NOT OPERATE THIS BANDSAW WITHOUT WHEEL, PULLEY, AND BLADE GUARDS IN PLACE.**
4. **WHEN REPLACING BLADES,** make sure teeth face down toward the table. The force of the cut is always down. Make sure the blade is properly tensioned after installing.
5. **WORKPIECE SHOULD ALWAYS BE FULLY SUPPORTED** by the table or some type of support fixture. Always support round stock in a V-block.
6. **DO NOT BACK WORKPIECE AWAY** from the blade while the saw is running. Plan your cuts so you always cut out of the wood. If you need to back the work out, turn the bandsaw off and wait for the blade to come to a complete stop. Do not twist or put excessive stress on the blade while backing work away. Inspect blade for damage such as kinks before continuing to use it. Discard it if necessary.
7. **BLADE SHOULD BE RUNNING AT FULL SPEED** before beginning a cut.
8. **ALWAYS FEED STOCK EVENLY AND SMOOTHLY.** Do not force or twist blade while cutting, especially when sawing small radii.
9. **THIS MACHINE IS NOT DESIGNED TO CUT METAL** or other material except wood.
10. **DO NOT MANUALLY STOP OR SLOW BLADE**. Allow it to come to a complete stop before you leave it unattended.
11. **ALL INSPECTIONS, ADJUSTMENTS, AND MAINTENANCE ARE TO BE DONE WITH THE POWER OFF** and the plug pulled from the outlet. Wait for all moving parts to come to a complete stop.
12. **HABITS – GOOD AND BAD – ARE HARD TO BREAK.** Develop good habits in your shop and safety will become second-nature to you.
13. **IF AT ANY TIME YOU ARE EXPERIENCING DIFFICULTIES PERFORMING THE INTENDED OPERATION, STOP USING THE BANDSAW!** Then contact our service department or ask a qualified expert how the operation should be performed.

⚠WARNING

To operate this or any power tool safely and efficiently, it is essential to become as familiar with it as possible. The time you invest before you begin to use your machinery will be time well spent. DO NOT operate this machine until you are completely familiar with the contents of this manual or serious personal injury may occur.

⚠CAUTION

No list of safety guidelines can be complete. Every shop environment is different. Always consider safety first, as it applies to your individual working conditions. Use this and other machinery with caution and respect. Failure to do so could result in serious personal injury, damage to equipment or poor work results.

SECTION 2: INTRODUCTION

We are proud to offer the Grizzly Model G0513 & G0514 Heavy-Duty Bandsaws. These bandsaws are part of a growing Grizzly family of fine woodworking machinery. When used according to the guidelines set forth in this manual, you can expect years of trouble-free, enjoyable operation and proof of Grizzly's commitment to customer satisfaction.

Each bandsaw features a deluxe extruded aluminum fence, a heavy-duty miter gauge, (2) 4" dust ports, a precision-ground cast iron table, a blade tensioner indicator, a height scale measurement, a micro-adjusting geared table, a quick change blade release/tensioning mechanism, pre-formed hinged steel wheel covers, ball bearing-style blade guides, and computer balanced aluminum wheels with polyurethane tires. Power is supplied by a 2 HP 110/220V single-phase motor. It is made in an ISO 9001 factory to exacting tolerances.

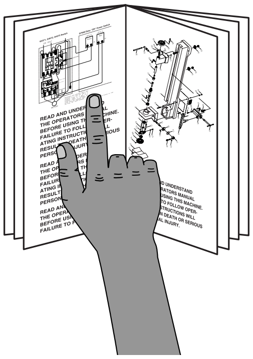
We are also pleased to provide this manual with the sander. It was written to guide you through assembly, review safety considerations, and cover general operating procedures. It represents our effort to produce the best documentation possible. If you have any comments regarding this manual, please write to us at the address below:

Grizzly Industrial, Inc.
C/o Technical Documentation
P.O. Box 2069
Bellingham, WA 98227-2069

Most importantly, we stand behind our machines. If you have any service questions or parts requests, please call or write us at the location listed below.

Grizzly Industrial, Inc.
1203 Lycoming Circle
Muncy, PA 17756
Phone: (570) 546-9663
Fax: (800) 438-5901
E-Mail: techsupport@grizzly.com
Web Site: http://www.grizzly.com

The specifications, drawings, and photographs illustrated in this manual represent the Model G0513 & G0514 Heavy-Duty Bandsaws at the time the manual was prepared. However, owing to Grizzly's policy of continuous improvement, changes may be made at any time with no obligation on the part of Grizzly. Whenever possible, though, we send manual updates to all owners of a particular tool or machine. Should you receive one, we urge you to insert the new information with the old and keep it for reference.



⚠WARNING

Lack of familiarity with the bandsaw can lead to accidents. Read this manual before assembly and operation. Become familiar with the machine and its operation before beginning any work.

SECTION 3: CIRCUIT REQUIREMENTS

220V Operation

⚠WARNING

A fire can result if the machine is not wired correctly. Make sure your wiring, receptacle, plug, and circuit breaker can handle a 10 amp, 220V current draw. If you are not sure that your electrical circuit can handle the current draw, get a qualified electrician to test your electrical system and do any required upgrades. Do not attempt to modify an existing circuit by only replacing the circuit breaker with one rated for a higher amperage draw than the wiring, receptacle, and plug are rated for.

⚠CAUTION

Using an extension cord on a machine operating at 220V increases the risk of fire and damage to the circuit. Do not use extension cords when operating a machine at 220V. Place the machine close to the power supply to eliminate the need for extension cords.

The Model G0513 & G0514 Heavy-Duty Bandsaw motors are prewired to operate at 220V. Under normal 220V use, the motor draws approximately 10 amps. Use a 10 amp circuit breaker or a 10 amp slow-blow fuse for 220V operation.

The Model G0513 & G0514 does not come with a plug. When operating at 220V, use a NEMA-style 6-15 plug and receptacle as shown in **Figure 1**.

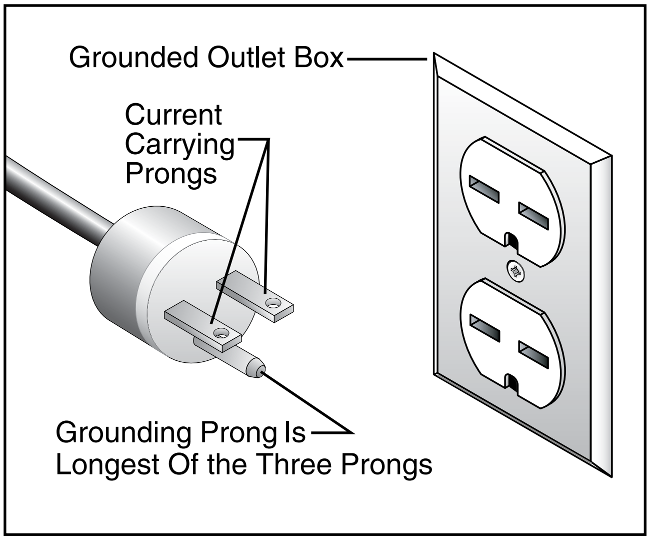


Figure 1. NEMA-style 6-15 plug and receptacle.

The circuit the Model G0513 or G0514 uses should be dedicated to that machine only. If frequent circuit failure occurs when using this machine, contact our Service Department or a qualified electrician.

110V Operation

⚠WARNING

A fire can result if the bandsaw is not wired correctly. Make sure your wiring, receptacle, plug, and circuit breaker can handle a 20 amp, 110V current draw. If you are not sure that your electrical circuit can handle the current draw, get a qualified electrician to test your electrical system and do any required upgrades. Do not attempt to modify an existing circuit by only replacing the circuit breaker with one rated for a higher amperage draw than the wiring, receptacle, and plug are rated for.

The motor supplied with the Model G0513 & G0514 Heavy-Duty Bandsaw can be operated at either 110V or 220V. The motor comes prewired for 220V. Refer to the wiring diagram at the back of this manual for information about rewiring motor operation for 110V.

Under normal use, the motor draws approximately 20 amps at 110V. Use a 20 amp circuit breaker or a 20 amp slow-blow fuse for 110V operation. If the motor is rewired for 110V, a suitable 110V plug must installed on the power cord. When operating at 110V, we recommend using a NEMA-style 5-20 plug and receptacle as shown in **Figure 2**.

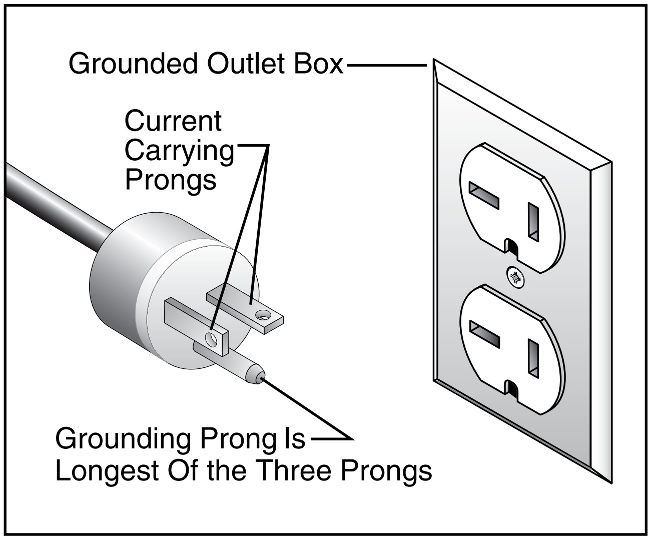


Figure 2. NEMA-style 5-20 plug and receptacle.

The circuit the Model G0513 or G0514 uses should be dedicated to that machine only. If frequent circuit failure occurs when using this machine, contact our Service Department or a qualified electrician.

Grounding

⚠WARNING

Electrocution or a fire can result if the bandsaw is not grounded correctly. Make sure all electrical circuits are grounded. Do not use the machine if it is not grounded.

NOTICE

The wire on the power cord with green or green and yellow striped insulation is the grounding conductor.

In the event of an electrical short, grounding provides electric current a path of least resistance to reduce the risk of electrical shock to the operator. Ground the power cord and this machine in accordance with all local codes and ordinances.

Operating the Model G0513 or G0514 when it is not properly grounded can result in electric shock or electrocution.

⚠CAUTION

You have been provided with basic electrical information, but it is not necessarily comprehensive. Failure to comply with local electrical codes and ordinances can result in electrocution or a fire. It is your responsibility to make sure all electrical work is done correctly.

SECTION 4: MACHINE FEATURES

External Features

Set up and operation instructions will be easier to understand if you become familiar with the location and names of the basic features.

Match up the feature list below with the letters in **Figures 3, 4, and 5** to identify the external bandsaw feature locations.

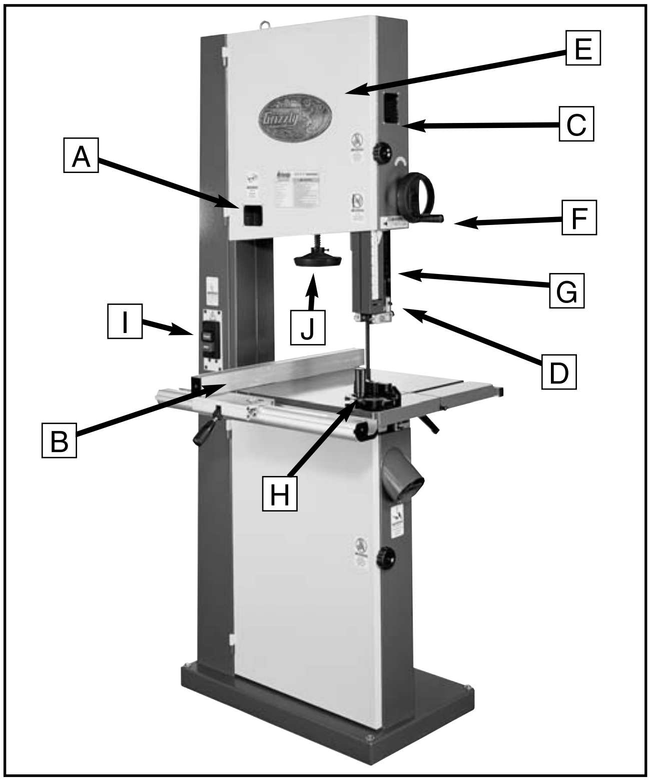


Figure 3. The front of the bandsaw.

A. Tension Indicator Window
B. Rip Fence
C. Blade Tracking Window
D. Ball Bearing Roller Guides
E. Hinged Wheel Cover
F. Guide Post Handwheel
G. Cutting Height Scale
H. Miter Gauge
I. On/Off Switch
J. Blade Tension Handwheel

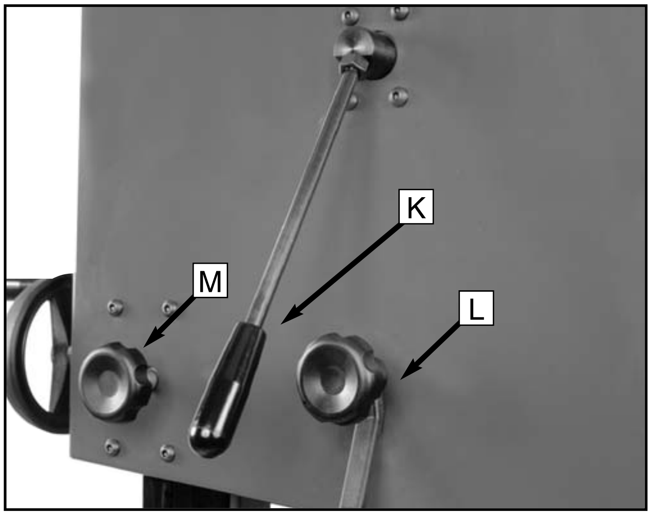


Figure 4. Back, top-side of the bandsaw.

K. Quick Release Blade Tension Lever
L. Blade Tracking Knob
M. Guide Post Lock Knob

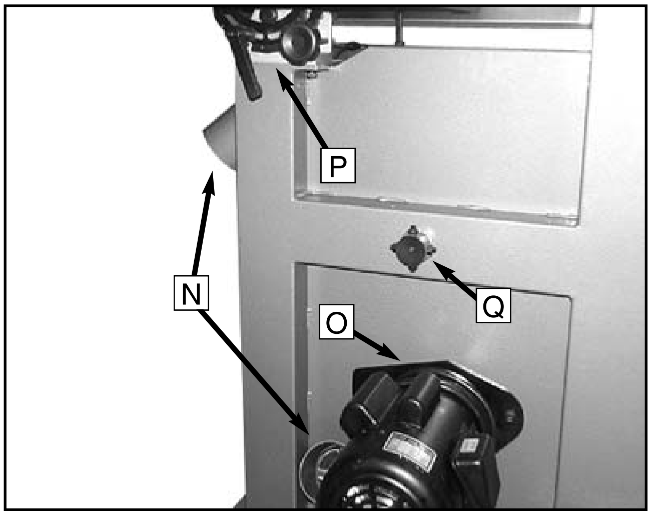


Figure 5. Back, lower-side of the bandsaw.

N. (2) 4" Dust Ports
O. 2 HP Motor
P. Table Tilt Controls
Q. Lower Blade Tracking Adjustment

Internal Features

The lower wheel compartment contains the wheel brush as shown in **Figure 6**. This brush is designed to sweep sawdust from the wheel tire as the bandsaw is operating.

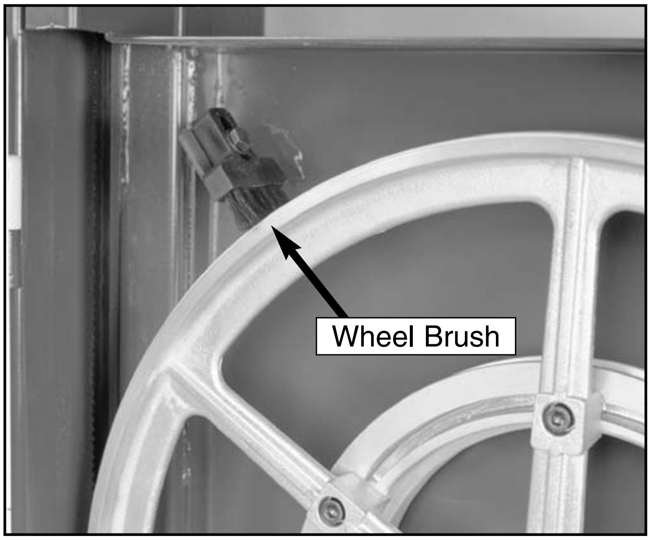


Figure 6. The wheel brush is located behind the lower hinged wheel cover.

The upper wheel housing contains the blade tension scale as shown in **Figure 7**. The scale is visible through a clear window positioned on the lower left side of the hinged wheel cover. The scale is used to aid in correctly tensioning the saw blade.

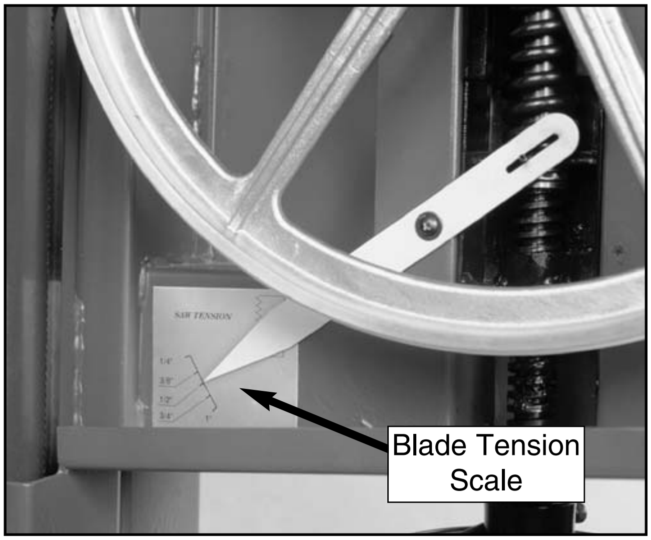
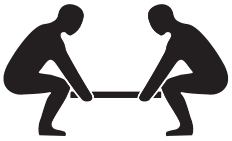


Figure 7. The blade tension scale is located behind the upper hinged wheel cover.

SECTION 5: SET UP

Unpacking



⚠WARNING

The Model G0513 & G0514 are heavy machines, weighing in at 266 lbs and 319 lbs. respectively. Personal injury can occur if the machine is moved without additional assistance. Seek the assistance of another person when moving or lifting the machine.

The Model G0513/G0514 was shipped from the manufacturer in a carefully packed carton. Inventory the machine parts and make sure everything was included in the shipment. If you discover the machine is damaged after you have signed for delivery, or that parts are missing, immediately call our Customer Service for advice.

Piece Inventory

Remove the parts from the shipping package. The following parts should be enclosed:

- Bandsaw Unit
- Table Assembly
- Miter Gauge
- Hardware Bag
- Fence Assembly

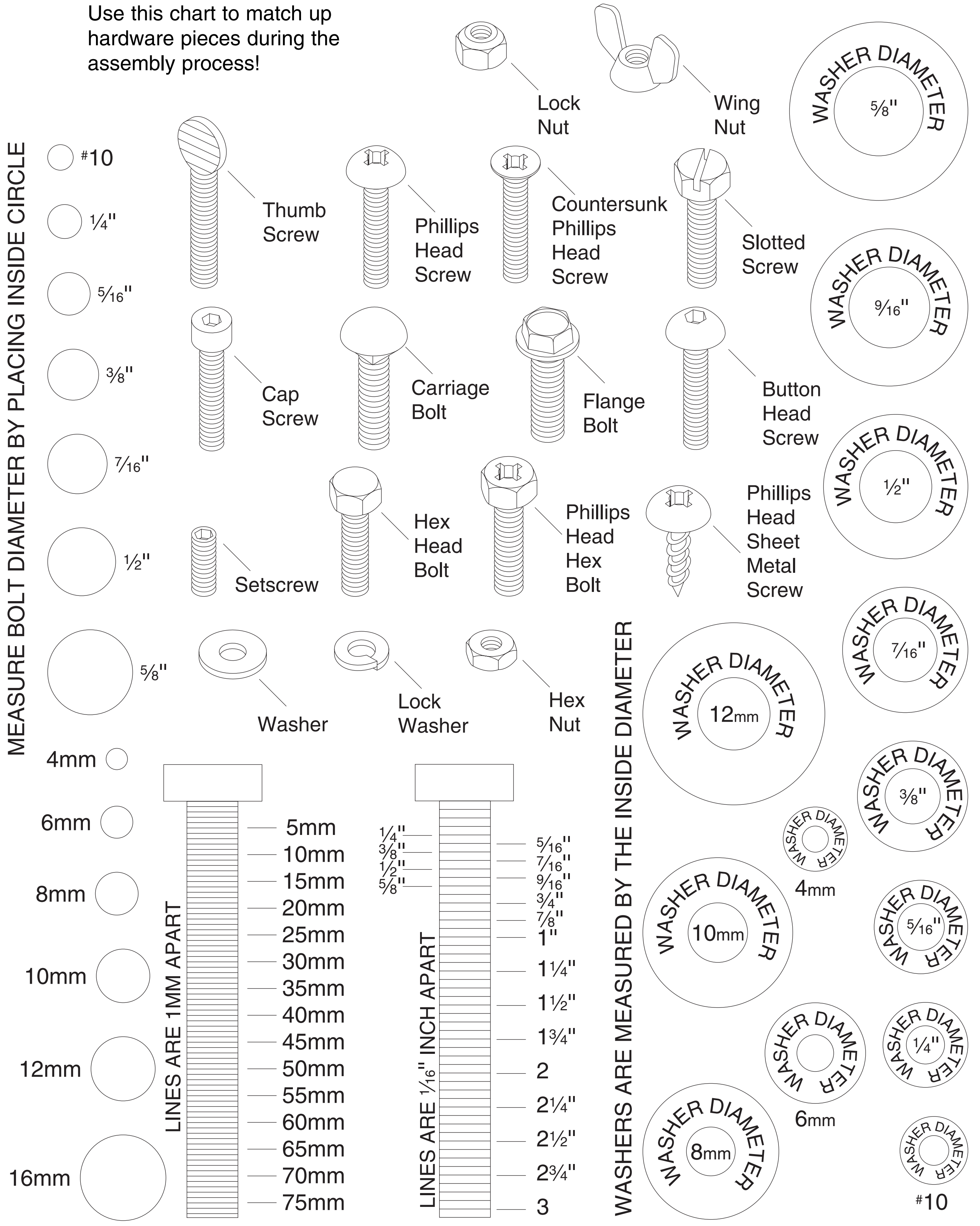
If any parts are missing or are damaged, please contact our Customer Service Department.

NOTICE

A part diagram and part list are located near the end of the manual. Use the diagram and list to identify missing parts or to supplement the assembly instructions provided in this manual.

Hardware Chart

Use this chart to match up hardware pieces during the assembly process!



Clean Up

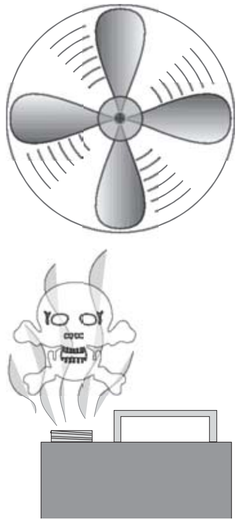
The unpainted surfaces are coated with a waxy oil to protect them from corrosion during shipment. Remove this waxy oil with a solvent cleaner or citrus-based degreaser such as Grizzly's G7895 Degreaser. To clean thoroughly, some parts may need to be removed. **The machine will operate best when the waxy oil is removed from all moving and sliding parts.** Chlorine-based cleaners and solvents will damage the painted surfaces of the machine. Follow the manufacturer's instructions when using any type of cleaning product.

⚠WARNING

Gasoline and petroleum-based products have low flash points which make them flammable. Explosion and burning can occur if these products are used. Do not use gasoline or petroleum products to clean the machine.

⚠WARNING

Smoking near solvents may ignite an explosion or fire causing serious personal injury. Do not smoke while using solvents.



⚠CAUTION

Many of the solvents commonly used to clean machinery can be toxic when inhaled or ingested. Always work in well-ventilated areas far from potential ignition sources when using solvents. Use care when disposing of waste rags and towels to be sure they do not create fire or environmental hazards.

Site Considerations

Floor Load

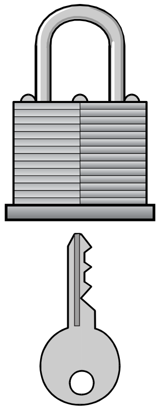
The Model G0513/G0514 is a heavy load with a medium footprint. Most commercial or home shop floors should be sufficient to carry the weight of the machine. Reinforce the floor if you question its ability to support the weight.

Working Clearance

Working clearances can be thought of as the distances between machines and obstacles that allow safe operation of every machine without limitation. Consider existing and anticipated machine needs, size of material to be processed through each machine, and space for auxiliary stands or work tables. Also, consider the relative position of each machine to one another for efficient material handling. Be sure to allow yourself sufficient room to safely run your machines in any foreseeable operation and keep dust collection hoses off the floor and out of the way.

Lighting

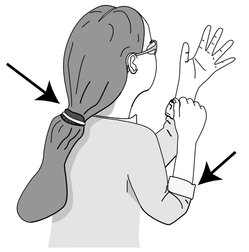
Lighting should be bright enough to eliminate shadows and prevent eye strain. Electrical circuits should be dedicated or large enough to handle combined motor amp loads. Be sure to follow local electrical codes for proper installation of new lighting or circuits.



⚠CAUTION

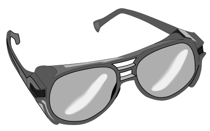
Make your shop "child safe." Ensure that your workplace is inaccessible to children by closing and locking all entrances when you are away. Never allow visitors in your shop when assembling, adjusting or operating equipment.

Beginning Assembly



⚠WARNING

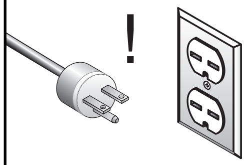
Keep loose clothing rolled up and out of the way of machinery and keep hair pulled back.



⚠WARNING

Wear safety glasses during the entire adjustment process. Failure to comply may result in serious personal injury.

Remove Saw Blade



⚠WARNING

Disconnect power to the machine when performing any maintenance, assembly or adjustments. Failure to do this may result in serious personal injury.

The saw blade needs to be removed before the table can be mounted to the bandsaw.

To remove the blade:

1. **Unplug the bandsaw!**

2. Release tension on the blade by rotating the quick release tension lever clockwise as shown in **Figure 8**.

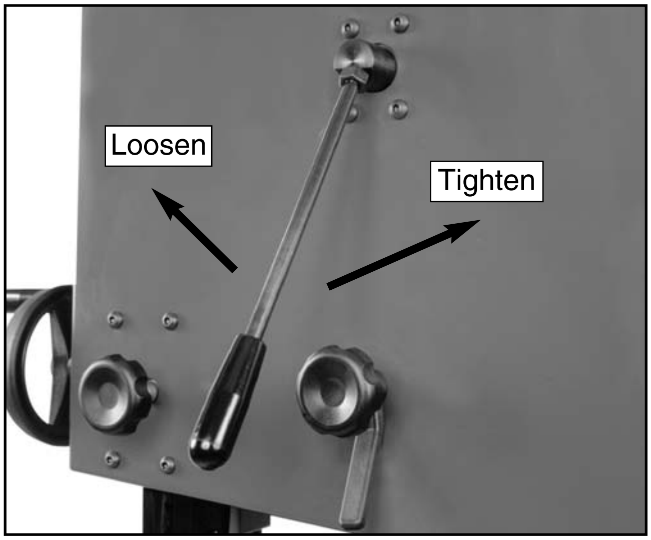


Figure 8. Quick release tension lever.

3. Remove the table insert and the table pin shown in **Figure 9**.

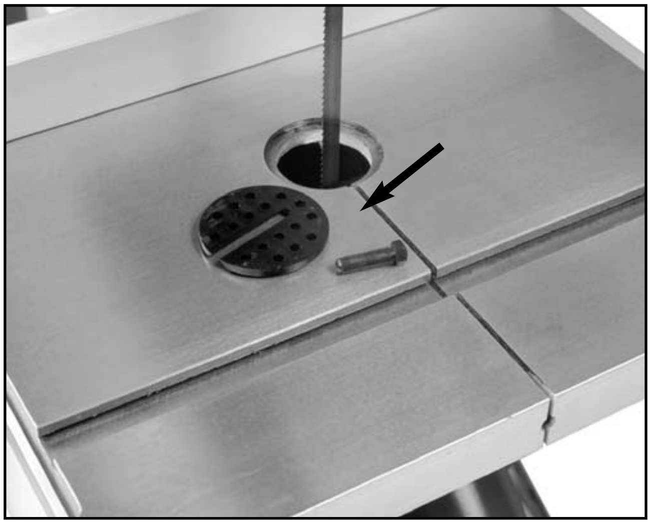


Figure 9. Table insert and pin.

4. Adjust the upper and lower blade guides away from the blade. Refer to the "Blade Guide" instructions on **Page 24** for more details.

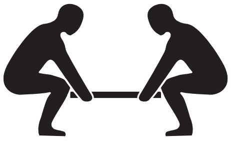
⚠WARNING

All saw blades are dangerous and may cause personal injury or death. To reduce the risk of being injured, wear leather gloves when handling saw blades.

5. Open the upper and lower wheel covers and slide the blade off both wheels.

6. Rotate the blade and slide it through the slot on the table.

Table



⚠CAUTION

Personal injury may occur if the table is lifted without assistance. Get help when placing the table on the trunnion.

NOTICE

Remove the blade before attempting to mount the table to the bandsaw.

To mount the table:

1. Make sure the blade has been removed before attempting to mount the table.

2. With the help of another person, lift the table onto the trunnion.

3. Mount the table to the trunnion as shown in **Figure 10** using the supplied hex bolts and washers.

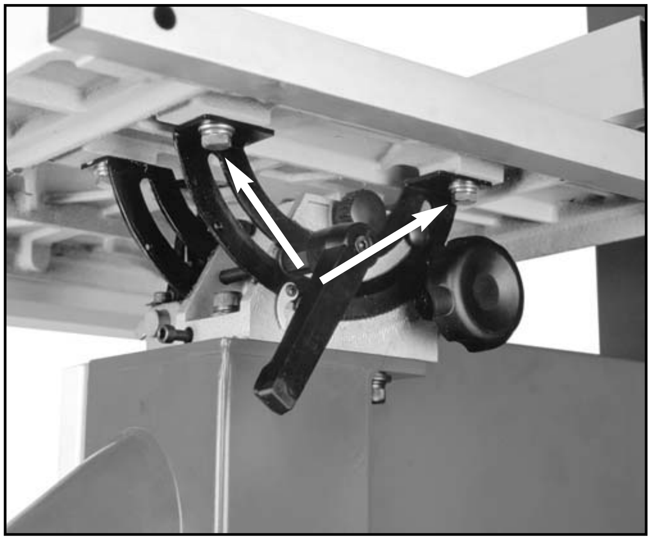
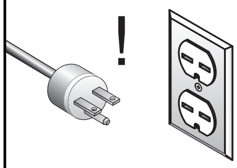


Figure 10. Table mounting hex bolts and washers.

Installing Saw Blade



⚠WARNING

Personal injury or death can occur if the bandsaw starts during blade changes. Disconnect power from the bandsaw before performing blade changes.

⚠WARNING

All saws blades are dangerous and can cause personal injury or death. To reduce the risk of being injured, wear leather gloves when handling saw blades.

To install the blade:

1. **Unplug the bandsaw!**
2. Make sure the upper and lower blade guides are adjusted away from the blade.
3. Make sure the quick release tension lever shown in **Figure 8** is released.
4. With the blade teeth pointing downward, slide the blade through the table slot.

NOTICE

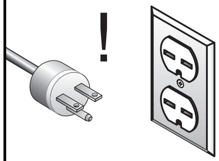
If the blade cannot be positioned with the teeth pointing downward, it may be inside-out. While wearing leather gloves, flip the blade rightside-out.

5. Slide the blade through the upper and lower blade guides, and mount it over the upper and lower wheels.
6. Tighten the quick release tension lever (**Figure 4, Item K**).
7. Using the blade tensioning controls shown in **Figure 3, Items A & J**, tension the blade until the tension scale reading corresponds to the width blade you are using.
8. Close the wheel covers.
9. Replace the table insert and table pin.
10. Keep the upper and lower blade guides adjusted away from the blade until the blade tracking has been adjusted.

⚠CAUTION

Cutting with the bandsaw before the blade tracking and tension have been adjusted could cause the blade to fall off the wheels resulting in operator injury or death. DO NOT perform any cutting operations at this time.

Blade Tracking



⚠WARNING

Personal injury or death can occur if the bandsaw starts while your hand is touching the bandsaw wheel during tracking adjustments. Disconnect power from the bandsaw before performing blade tracking adjustments.

During operation, the blade needs to ride on the center of the upper and lower wheels. Adjusting the path the blade travels on is called blade tracking.

To adjust the blade tracking:

1. **Unplug the bandsaw!**

2. Make sure the upper and lower blade guides are adjusted away from the blade.

3. Open the upper wheel cover.

4. Using the blade tensioning controls shown in **Figures 3 & 4, Items A, J & K**, tension the blade until the tension scale reading corresponds to the width blade you are using.

5. Loosen the tracking control lock lever shown in **Figure 11** by turning it counter-clockwise.

6. Turn the tracking control knob clockwise/counterclockwise while turning the upper wheel by hand until the blade tracks centered on the wheel.

⚠CAUTION

Be careful when turning the bandsaw wheels by hand. The aluminum spokes may have sharp edges and the blade teeth may extend beyond the edge of the wheel and cause injury.

7. Turn the upper wheel by hand at least three rotations to make sure the blade tracks on the center of the wheel.

8. Tighten the tracking control lock lever.

9. Close the wheel cover.

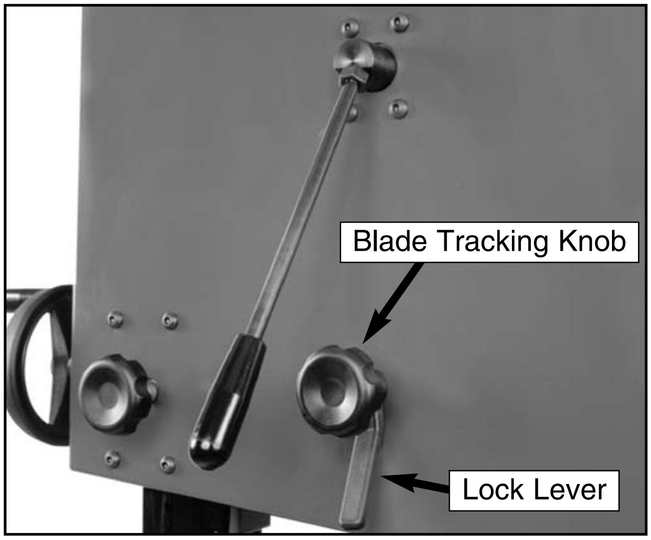
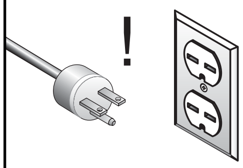


Figure 11. Release lock lever before adjusting tracking.

Positive Stop



⚠WARNING

Personal injury or death can occur if the bandsaw starts during table adjustment. Disconnect power from the bandsaw before performing table adjustments.

The positive stop allows the table to be quickly and accurately returned to the horizontal (0˚) position after being adjusted to a different angle.

To set up the positive stop:

1. **Unplug the bandsaw!**
2. Locate the positive stop bolt under the table as shown in **Figure 12**.
3. Loosen the jam nut on the positive stop bolt.
4. Raise the upper blade guide to the highest position.

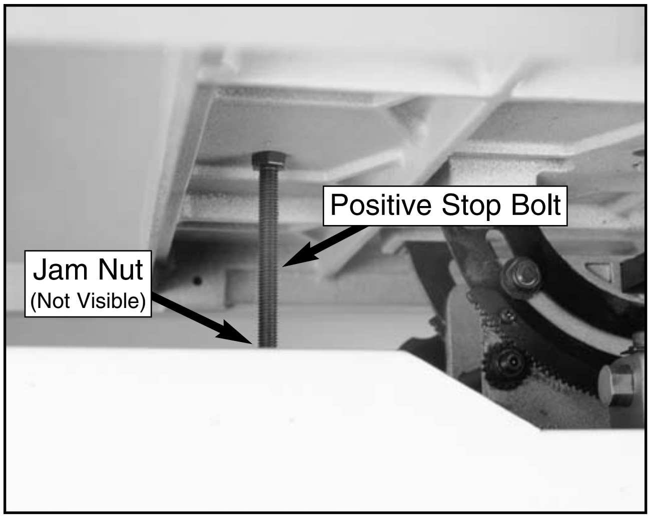


Figure 12. Positive stop bolt and jam nut.

5. Place a 6" square on the table surface and determine if the blade is square to the table surface as shown in **Figure 13**.

- **If the blade is square with the table surface:** Lock the table into position, tighten the jam nut on the positive stop bolt, and adjust the scale pointer to the 0˚ position. Continue to the next page.
- **If the blade is NOT square to the table surface:** Raise or lower the positive stop bolt until the blade is square to the table surface. When square, lock the table into position, tighten the jam nut on the positive stop bolt, and adjust the scale pointer to the 0˚ position. Continue to the next page.

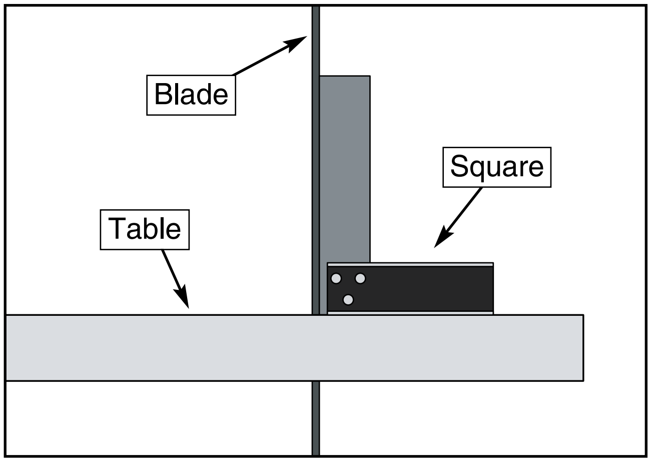


Figure 13. Squaring side of blade and table.

Dust Collection

The Model G0513/G0514 is equipped with (2) 4" dust ports.

To hook up the dust collection system:

1. Add a "Y" connector to one of your dust collection branch lines.
2. Connect each branch of the "Y" connector to each of the bandsaw's 4" dust collection ports.

Depending upon your existing dust collection system, additional adapters and/or hoses may need to be purchased to connect the Model G0513/G0514 to your dust collection system.

Fence Assembly

The threaded holes on the front and back of the table are mounting holes for the fence rails.

To assemble the fence:

1. Install the rear fence rail to the table with (2) M6-1.0 x 15 cap screws. *If a cap screw falls inside of the rear fence rail, remove the rail end plug to retrieve it.*
2. Install the front fence rail to the table with (2) M6-1.0 x 20 hex bolts and (2) M6 lock washers. Make sure the scale is face up.

Set the fence on the front and rear rails. The fence should easily slide across the rails. If the fence rubs on the table surface, the height adjustment screw on the bottom of the fence needs to be threaded out a small amount. This raises the riding height of the fence.

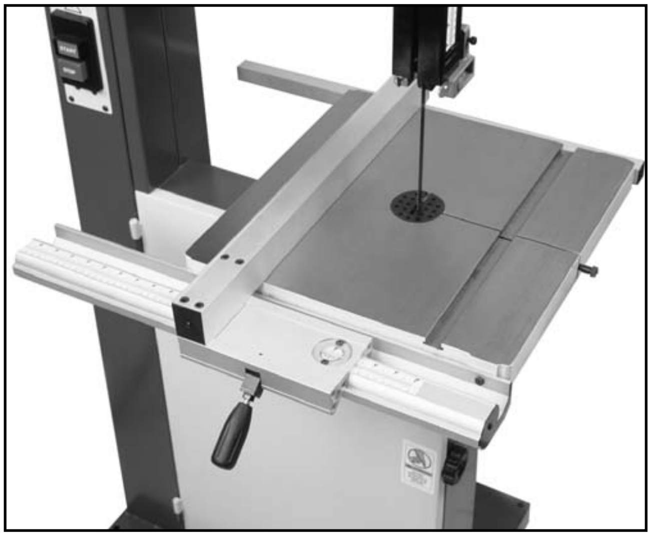


Figure 15. Fence assembly.

Fence Adjustment

The fence face needs to be parallel to the table miter slot.

To adjust the fence parallel to the miter slot:

1. Move the fence to the right side of the saw blade.
2. Loosen the 4 cap screws located on the top face of the fence.
3. Adjust the fence face parallel with the edge of the miter slot. Carefully tighten down the 4 cap screws.

NOTICE

Adjusting the fence parallel to the miter slot does not guarantee straight cuts. The miter slot may need to be adjusted parallel to the side of the blade. Refer to the "Table Alignment" instructions.

Table Alignment

Correct table alignment is needed to achieve accurate cuts.

To adjust the miter slot square to the blade:

1. Loosen the trunnion bolts underneath the table.
2. Place a straightedge along the side of the blade. The straightedge should touch the front and the back of the blade.
3. Use a fine ruler to gauge the distance between the blade and the miter slot as shown in **Figure 16**. The distance you measure should be the same at both the front and the back of the table.
4. Adjust the table in the desired direction and secure it in position by retightening the trunnion bolts.

The table should also be 90˚ to the back of the blade as shown in **Figure 17**. If the table is not perpendicular to the back of the blade, shim the table in the desired direction by placing washers between the table and the two trunnions.

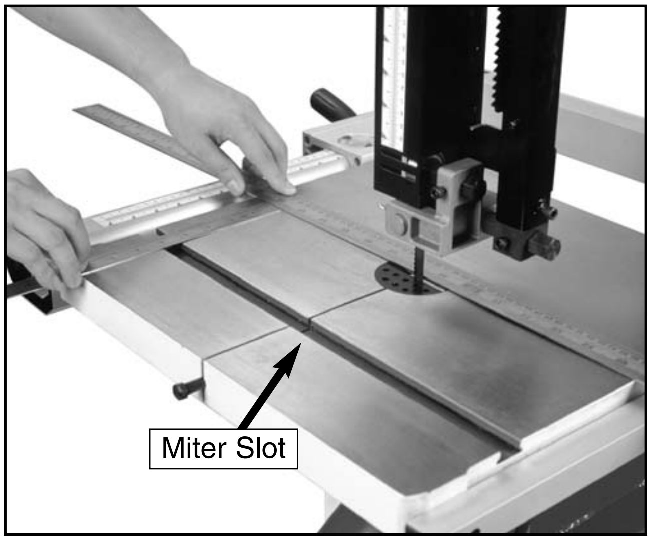


Figure 16. Squaring miter slot to blade.

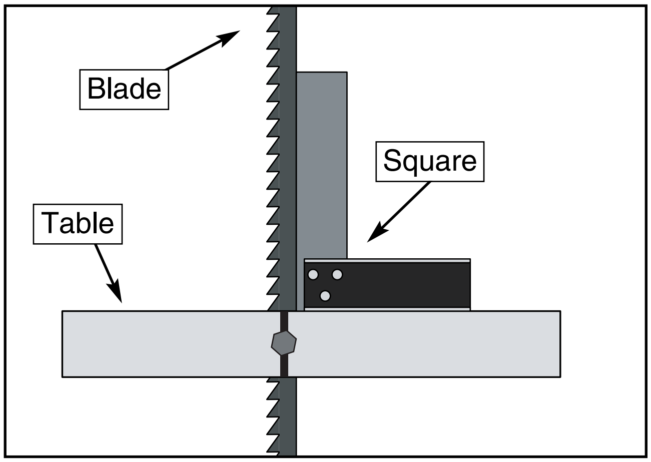


Figure 17. Squaring back of blade and table.

Start Up

WARNING

Adjusting or troubleshooting a machine while it is running could cause personal injury or death. DO NOT attempt to investigate or adjust any features of the machine while it is running. Wait until the machine is turned off, unplugged and all working parts have come to a stop!

Before starting the machine:

1. Read this manual and make sure you take all safety precautions before operating this machine.
2. Make sure blade has been tracked and tensioned according to the "Blade Tracking" instructions on **Page 17**.
3. Make sure that any tools or foreign objects have been removed from the machine.
4. Review *Section 2: Circuit Requirements* and make sure all wiring is correct.
5. Keep your finger on the *STOP* button during the entire test run of the machine.

Turn the bandsaw on and make sure your hand is on the *STOP* button in case you need to shut the machine off immediately. The machine should run smoothly, with little or no vibration.

Blade Tension

NOTICE

Adjusting the final blade tension setting requires the machine to be turned on.

The blade must be tensioned correctly for optimum performance. The tension scale is viewable through the window on the upper wheel cover.

To adjust the blade tension:

1. Adjust the upper and lower blade guides shown in **Figure 18** away from the blade.
2. Close the wheel covers shown in **Figure 18**.
3. Tension the blade until the tension scale reading corresponds to the width blade you are using.

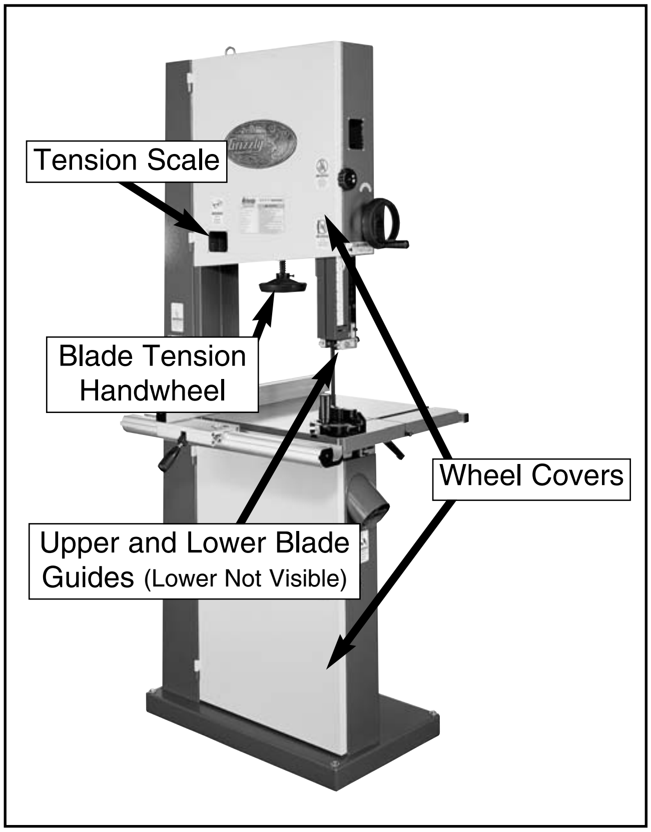


Figure 18. Blade tension handwheel.

4. Turn the machine on.

5. Release the tension one quarter of a turn at a time. Do this very slowly. When you see the bandsaw blade start to flutter, stop decreasing the tension.

6. Now, slowly increase the tension until the blade stops fluttering. Tighten the tension one more quarter of a turn.

7. Look at what the tension gauge reads and use that as a guide for tensioning your blade in the future.

If the tension seems correct, turn the bandsaw off and make the other adjustments, and test run. If the blade does not cut properly, the tension may be incorrect. Re-adjust the tension. New blades often stretch with use. However, removing the tension from the blade when not in use will reduce stretching and extend your blade life.

NOTICE

The final blade tracking needs to be adjusted after the blade is correctly tensioned.

Fine Tune Tracking

NOTICE

Adjusting the final blade tracking setting requires the machine to be turned on.

To fine tune the tracking:

1. Close the wheel covers and turn the bandsaw on.

2. Observe the blade tracking path through the clear window on the right edge of the bandsaw as shown in **Figure 19**.

3. Using the tracking controls shown in **Figures 3 & 4, Items A, J & K**, adjust the blade so it tracks on the center of the wheel.

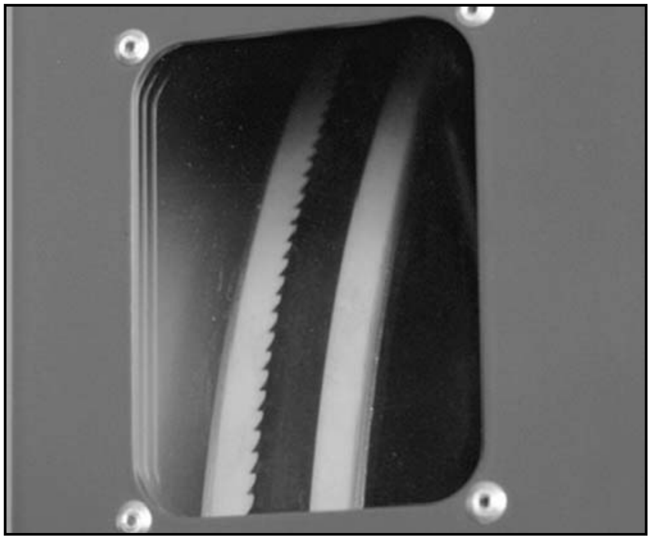
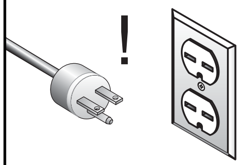


Figure 19. Blade tracking window.

Blade Guides



⚠WARNING

Personal injury or death can occur if the bandsaw starts during blade guide adjustment. Disconnect power from the bandsaw before performing blade guide adjustment.

Once the blade is tracking correctly, the upper and lower blade guides need to be adjusted.

To adjust the upper blade guide:

1. **Unplug the bandsaw!**
2. Loosen cap screw #1 shown in **Figure 20** and slide the support bearing away from the blade.

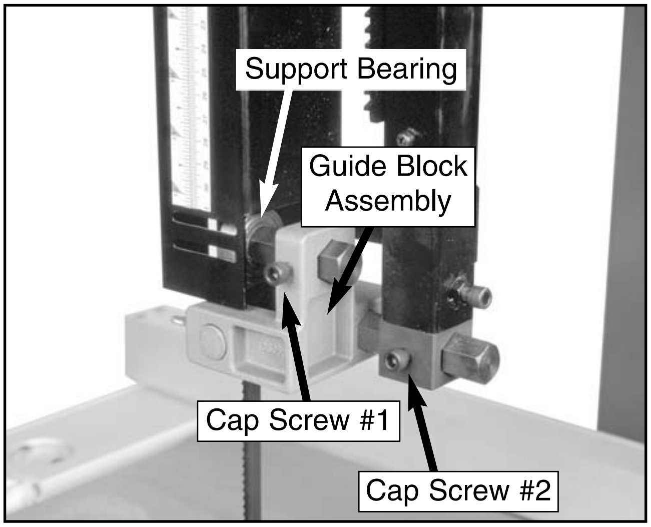


Figure 20. Back of upper blade guide.

3. Loosen the thumb screws shown in **Figure 21** and slide the guide bearings away from the blade.
4. Loosen cap screw #2 shown in **Figure 20** and adjust the guide block assembly until the front edge of the guide bearings are aligned 1/16" behind the gullet line as shown in **Figure 22**. Retighten cap screw #2.

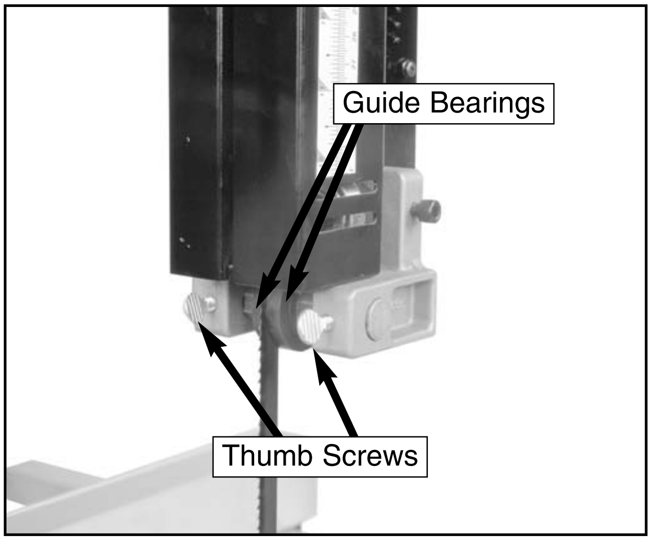


Figure 21. Front of upper blade guide.

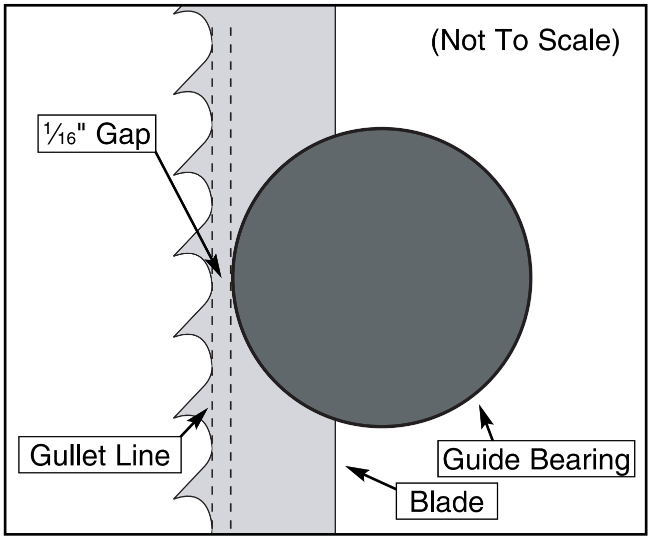


Figure 22. Correct guide bearing alignment against the blade.

5. Slide the guide bearings against the side of the blade. Make sure the front edge of the bearings are still behind the gullet line. The gap between the face of each guide bearing and the side of the blade needs to be the same as the thickness of a dollar bill or approximately 0.004" as shown in **Figure 23**. Tighten the thumb screws once the guide bearings are correctly set.

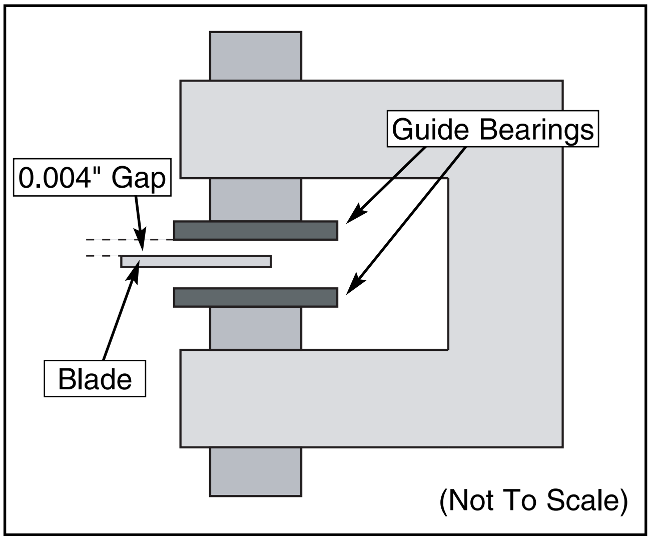


Figure 23. Correct gap between the guide bearings and the blade.

6. Slide the support bearing forward against the back edge of the blade and then back the bearing off approximately 0.016" as shown in **Figure 24**. Tighten cap screw #1 to secure the bearing in place.

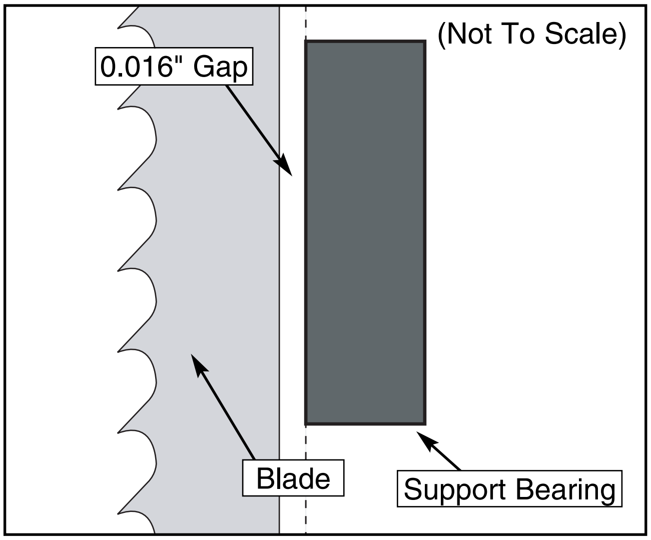
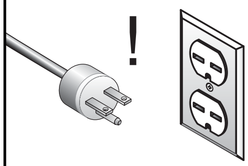


Figure 24. Correct gap between the support bearing and the blade.



⚠WARNING

Personal injury or death can occur if the bandsaw starts during blade guide adjustment. Disconnect power from the bandsaw before performing blade guide adjustment.

To adjust the lower blade guide:

1. **Unplug the bandsaw!**
2. Loosen cap screw #1 shown in **Figure 25** and rotate the adjustment knob to slide the support bearing away from the blade.

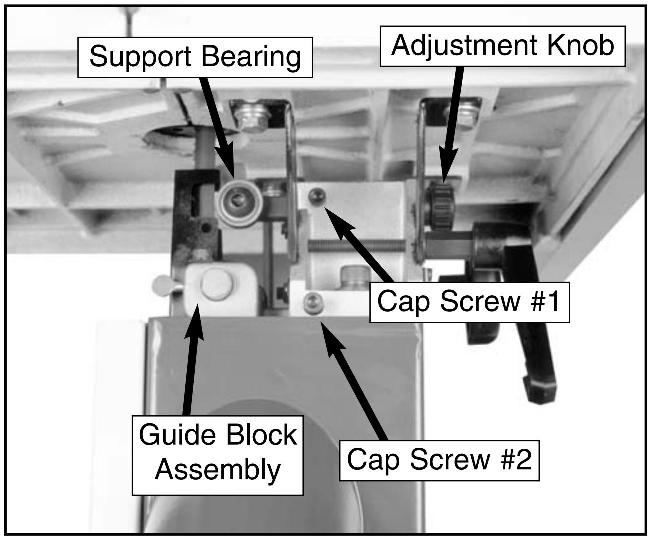


Figure 25. Side of lower blade guide.

3. Remove the cap screws shown in **Figure 26** and remove the blade guards.

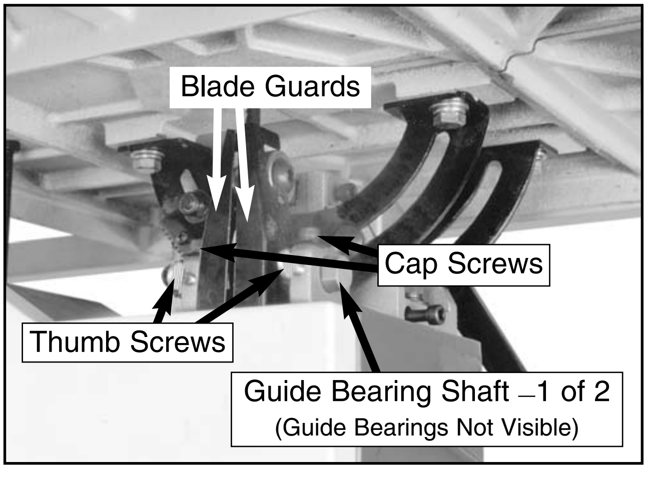


Figure 26. Front of lower blade guide.

4. Loosen the thumb screws shown in **Figure 26** and slide the guide bearings away from the blade.

5. Loosen cap screw #2 shown in **Figure 25** and adjust the guide block assembly until the front edge of the guide bearings are aligned 1⁄16" behind the gullet line as shown in **Figure 27**. Retighten cap screw #2.

6. Slide the guide bearings against the side of the blade. Make sure the front edge of the bearings are still behind the gullet line. The gap between the face of each guide bearing and the side of the blade needs to be the same as the thickness of a dollar bill or approximately 0.004" as shown in **Figure 28**. Tighten the thumb screws once the guide bearings are correctly set.

7. Turn the adjustment knob shown in **Figure 25** to slide the support bearing forward against the back edge of the blade and then back the bearing off approximately 0.016" as shown in **Figure 29**. Tighten cap screw #1 to secure the bearing in place.

8. Re-install the blade guards.

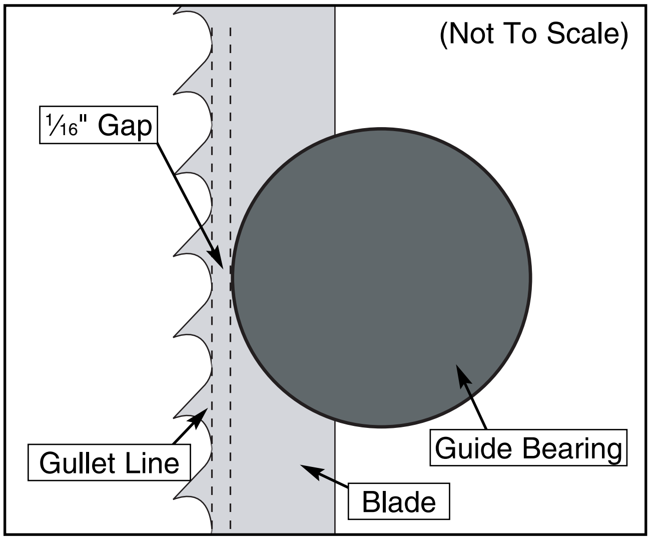


Figure 27. Correct guide bearing alignment against the blade.

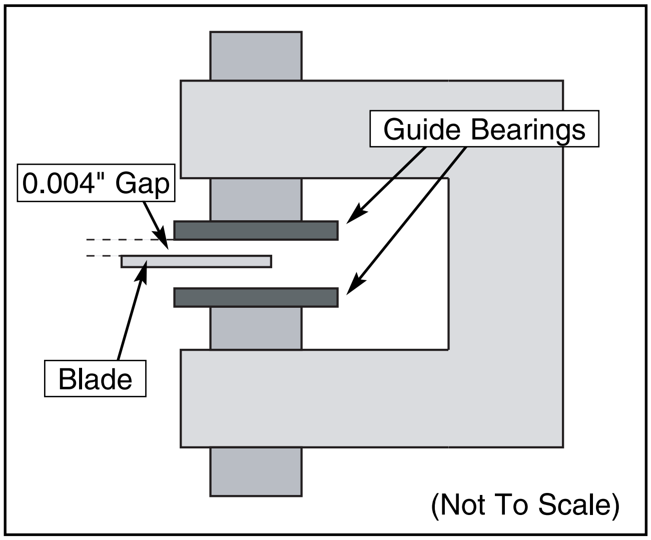


Figure 28. Correct gap between the guide bearings and the blade.

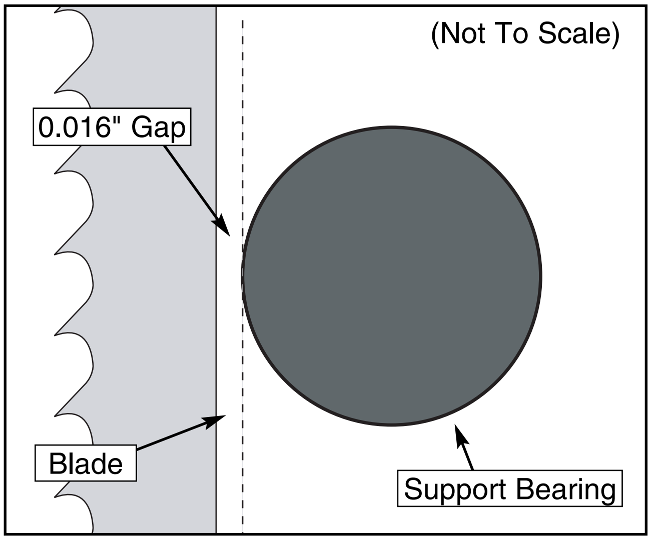
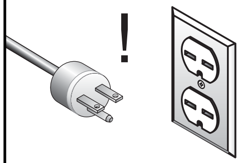


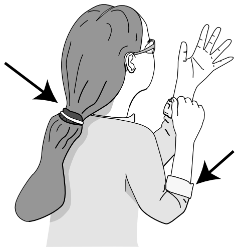
Figure 29. Correct gap between the support bearing and the blade.

SECTION 6: OPERATIONS



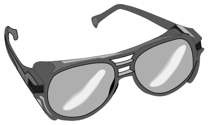
⚠WARNING

Disconnect power to the machine when performing any maintenance, assembly or adjustments. Failure to do this may result in serious personal injury.



⚠WARNING

Keep loose clothing rolled up and out of the way of machinery and keep hair pulled back.



⚠WARNING

Wear safety glasses during the entire operations process. Failure to comply may result in serious personal injury.

⚠CAUTION

Always wear a dust mask when operating the bandsaw. Using this machine produces sawdust which may cause allergic reactions or respiratory problems.

⚠CAUTION

Long term exposure to this machine during operation may cause hearing loss. Wear approved hearing protection to minimize this risk!

Guide Post

The guide post moves up and down on a rack-and-pinion track that is adjusted by turning the guide post handwheel shown in **Figure 30.** The upper blade guide assembly is attached to the bottom end of the guide post. The guide post/upper blade guide assembly is set correctly when the bottom edge of the guide bearings are approximately ¼" above the top surface of the workpiece.

To adjust the guide post:

1. Loosen the guide post lock knob shown in **Figure 30**.
2. Turn the guide post handwheel shown in **Figure 30** to raise or lower the guide post/upper blade guide assembly to the desired height.
3. Tighten the guide post lock knob.

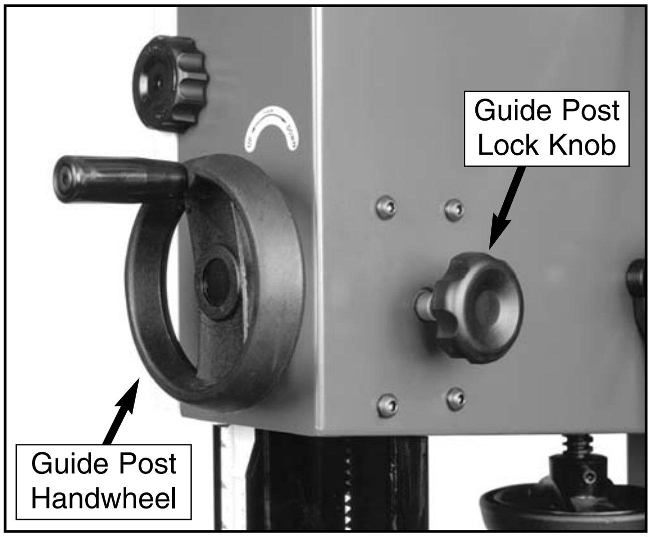
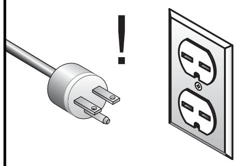


Figure 30. Release the guide post lock knob before adjusting the guide post handwheel.

Table Tilt



WARNING

Personal injury or death can occur if the bandsaw starts during table adjustment. Disconnect power from the bandsaw before performing table adjustments.

The table can be tilted 10˚ to the left and 45˚ to the right for performing angled cuts.

To adjust the table tilt:

1. **Unplug the bandsaw!**

2. Loosen the lock handle on the table trunnion shown in **Figure 31**.

NOTICE

When tilting the table to the left, the positive stop bolt must be removed. Page 18 describes this operation in more detail.

3. Turn the table tilt knob shown in **Figure 31** to adjust the table to the desired angle. Use the angle indicator scale on the trunnion bracket to find the desired angle.

3. Retighten the lock handle to secure the table.

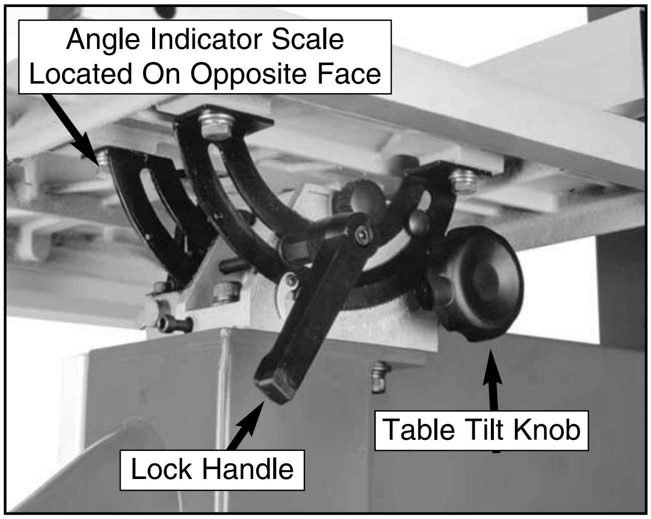


Figure 31. Release the lock handle before adjusting the table tilt knob.

Ripping

NOTICE

Using the fence scale requires calibration to the specific blade installed on the bandsaw. Recalibrate the scale after changing or adjusting the blade. Test recalibration using scrap wood.

Ripping is cutting with the grain direction of the workpiece. Ripping man-made wood products like plywood is cutting parallel to the longest side.

To make a rip cut:

1. Set the fence to the desired width of cut on the fence rail scale.
2. Adjust the guide rail/blade guide assembly to the correct height.
3. Joint one long edge of the workpiece on a jointer.
4. Using a push stick, feed the workpiece through the saw blade as shown in **Figure 32**. The jointed edge of the workpiece must be against the fence during this operation.

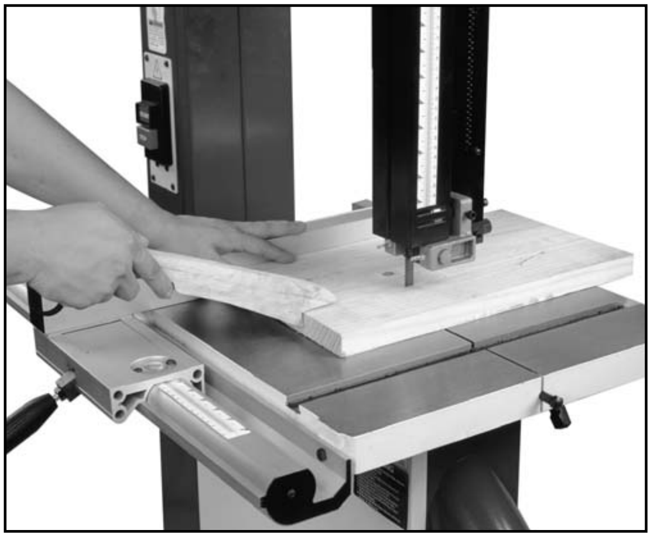


Figure 32. Ripping with a push stick.

Scale Recalibration

Recalibrate the scale after changing or adjusting the blade, or when the scale is not producing accurate cuts. Test recalibration using scrap wood.

To recalibrate the scale:

1. Adjust the fence to any position along the rail.
2. Joint one long edge of a scrap piece on a jointer.
3. Using a push stick, feed the workpiece through the saw blade. The jointed edge of the workpiece must be against the fence during this operation.
4. Measure the width of the cut workpiece. The width of the workpiece should be the same as the reading on the fence scale.
5. If the reading on the scale is not the same as the width of the cut workpiece, loosen the screws on the magnifying window as shown in **Figure 33** and adjust it to match the width of the cut workpiece.
6. Carefully tighten the screws and the scale is now correctly calibrated.

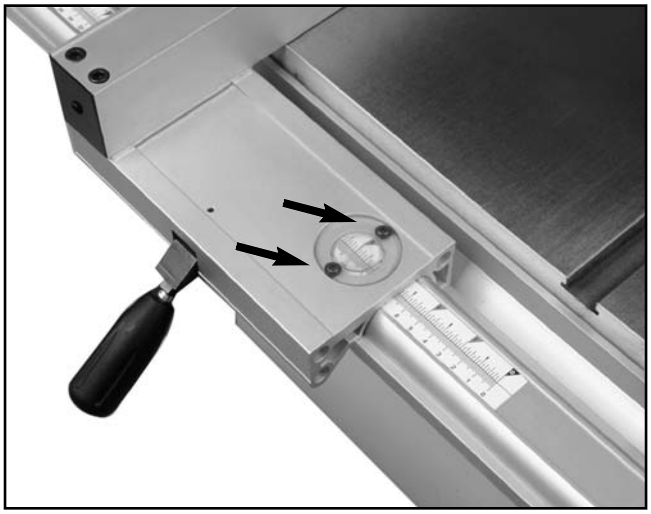


Figure 33. Scale recalibration screws.

Crosscutting

Crosscutting is cutting against the grain direction of the workpiece. Crosscutting man-made wood products like plywood is cutting parallel to the shortest side.

To make a 90˚ crosscut:

1. Adjust the miter gauge to the 90˚ position.
2. Adjust the guide rail/blade guide assembly to the correct height.
3. Position the workpiece against the miter gauge and line up the cut with the blade.
4. While holding the workpiece against the miter gauge, feed the workpiece through the saw blade as shown in **Figure 34**.

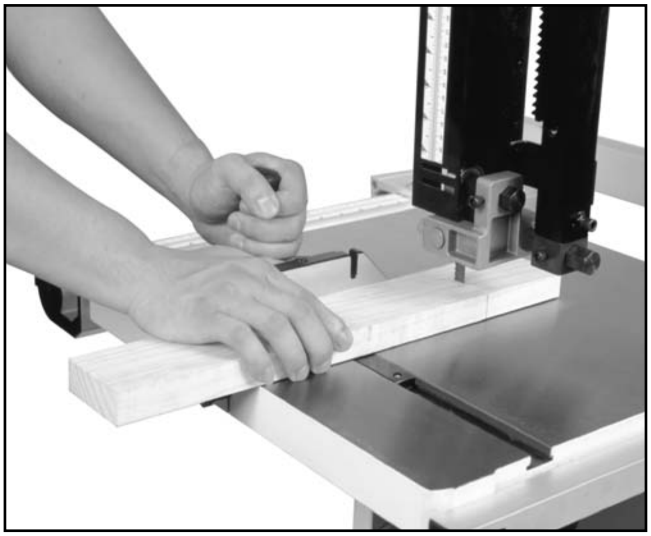


Figure 34. Crosscutting with a push stick.

Resawing

NOTICE

Resawing requires the blade to be perpendicular to the table surface. Instructions on making the blade perpendicular to the table surface are in *Section 5: Set Up.*

Resawing, as shown in **Figure 35**, is cutting a board into two thinner pieces. The width and length dimensions remain the same. The maximum width workpiece that can be resawn is limited to 12" on the Model G0513 & G0514.

To make a resaw cut:

1. Install the widest blade available for your bandsaw when performing resaw operations. The cut will be straighter and more accurate. The best tooth style is a hook or a skip tooth and should have between 3 and 6 teeth-per-inch.
2. Adjust the guide post/blade guide assembly to the desired height.
3. Joint one face of the workpiece on a jointer.
4. Using a push paddle, slowly feed the workpiece through the saw blade as shown in **Figure 35**. The jointed face of the workpiece must be against the fence during this operation.

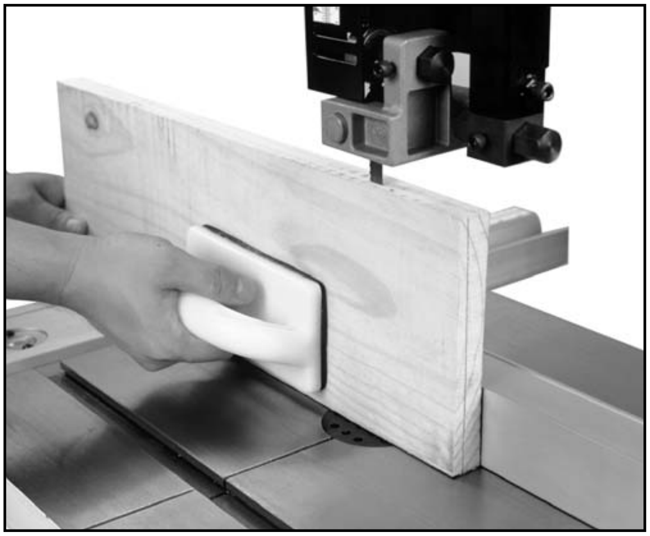


Figure 35. Resawing lumber.

NOTICE

Blade lead, or wandering, is common when resawing. See the next section for instructions on correcting blade lead.

Blade Lead

It is common for a bandsaw blade to wander off the cut line when sawing as shown in **Figure 36**. This is called blade lead.

To correct blade lead:

1. Check that the miter slot or fence is parallel to the blade line.
2. Check that you have proper blade tension. If the blade tension is correct and it is not convenient to replace the blade, compensate for lead by skewing the fence or adjusting the table.

To skew the fence:

1. Obtain a piece of scrap wood that is approximately ¾" thick x 3" wide x 17" long. On a wide face of the board, draw a straight line parallel to the long edge.
2. Slide the fence out of the way and cut freehand along the line. Stop at the halfway point. Turn the bandsaw off and *wait for the blade to stop.*
3. Carefully clamp the board to the bandsaw table. Now slide the fence over to the board so it barely touches one end of the board.
4. Loosen the 4 skewing cap screws on top of the fence as shown in **Figure 36.**
5. Skew the fence left or right so it is parallel to the edge of the scrap piece.
6. While maintaining the skew, tighten the cap screws.

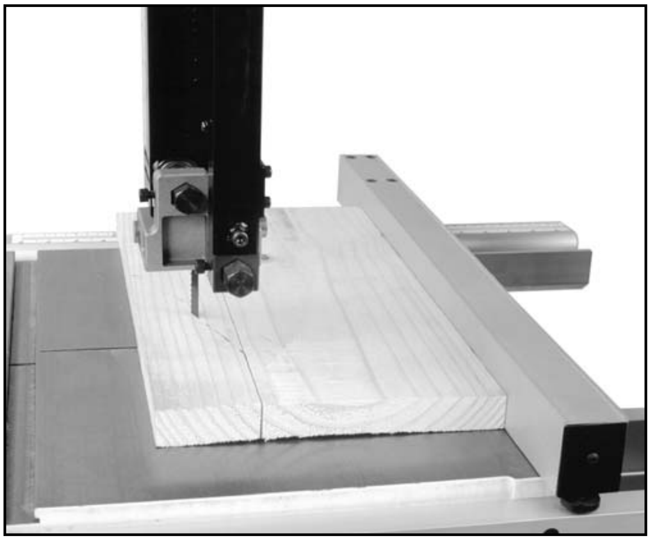


Figure 36. Blade leading away from line of cut.

To compensate for blade lead if making straight crosscuts using the miter gauge, you will need to shift the table.

To shift the table:

1. On a scrap piece of wood, mark a line that is perpendicular to the front edge.
2. Starting where the line begins, cut the board by pushing it through the blade with the miter gauge.
3. Loosen the table mounting bolts. Shift the table to compensate for the blade lead.
4. Repeat **Steps 1-3** until the blade cuts straight.

NOTICE

Blade lead adjustments will change when new blades are mounted on the saw.

Cutting Curves

NOTICE

Refer to Figure 40 on Page 33 to determine the best blade for cutting various curves.

When cutting curves, simultaneously feed and turn the stock carefully so that the blade follows the layout line without being twisted. If a curve is so abrupt that it is necessary to repeatedly back up and cut a new kerf, use either a narrower blade or a blade with more teeth-per-inch (TPI). A blade with more TPI can cut relatively tighter curves, though the cut is usually rougher than cuts produced by a blade with a medium amount of TPI.

Always make short cuts first, then proceed to the longer cuts. Relief cuts will also reduce the chance that the blade will be pinched or twisted. Relief cuts are cuts made through the waste portion of the workpiece and are stopped at the cut line. Make relief cuts from the workpiece edge to points along the cut line where there are sharp changes in direction. As you cut along the layout line, waste wood is released from the workpiece, alleviating any pressure on the back of the blade.

NOTICE

Relief cuts require you to back the blade out of the cut. Make relief cuts as short as possible so the blade only has a short distance to back out.

Stacked Cuts

One of the benefits of a bandsaw is its ability to cut multiple copies of a particular shape by stacking a number of workpieces together.

NOTICE

Before making stacked cuts, make sure both the table and the blade are properly adjusted to 90°. Refer to the "Table Tilt" and "Table Stop" sections in *Section 2: Set Up*. If the table and blade are NOT 90° to one another, NONE of the cut-out workpieces will be the same size.

To complete a stacked cut:

1. Each of the workpieces in the stack should be identical in dimension.

2. Draw the project cut lines on one of the workpieces. There should be at least an inch of scrap area around the outside of the project cut lines.

3. Stack the identically shaped workpieces on top of one another. Make sure they are aligned even on all sides.

4. Secure the workpieces to one another using the scrap area on the outside of the project cut lines. *Hot glue on the edges of the workpieces works well, as does shooting a few brad nails through the scrap area. If brad nails are used, make sure they are located far enough away from the cut lines to avoid accidentally cutting into them.*

5. Draw relief lines where the blade or workpiece may become strained when cutting. Refer to the "Cutting Curves" instructions at the beginning of this page for more information on relief cuts.

6. Make all of the cuts on the relief cut lines.

7. Cut out the final shape of the workpiece by cutting along the project cut lines as shown in **Figure 37**.

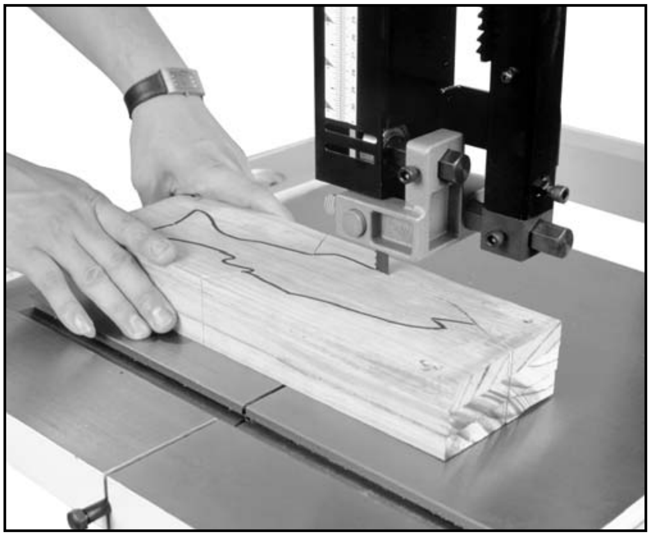


Figure 37. Cutting multiple pieces at once.

Blade Speed

The Model G0513 blade speed can be adjusted to 1600 or 3300 FPM. The Model G0514 blade speed can be adjusted to 1200 or 3200 FPM. Speed adjustments are made by moving the V-belt position on the motor and wheel pulleys.

NOTICE

Most woodcutting can be performed successfully at the higher blade speeds. Slower blade speeds generally produce better results when cutting hardwoods, intricate curves, or when an exceptionally smooth cut is desired.

To adjust the blade speed:

1. **Unplug the bandsaw!**

2. Loosen the motor mount hex bolts.

3. Adjust the motor so the V-belt can be moved.

4. Use **Figure 38** to locate the correct v-belt position for the desired blade speed.

5. Adjust the motor so the V-belt is tensioned around the pulleys and tighten the hex bolts.

6. Check the V-belt tension. When tensioned correctly, the V-belt can be deflected approximately ¾" as shown in **Figure 39**.

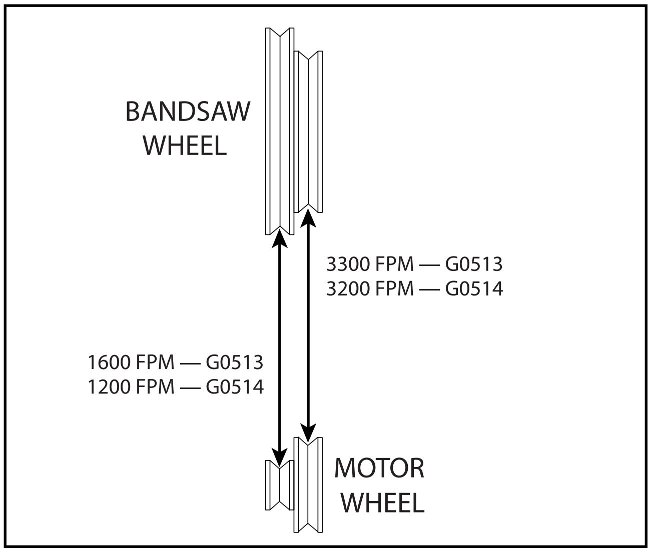


Figure 38. Determine V-belt speed.

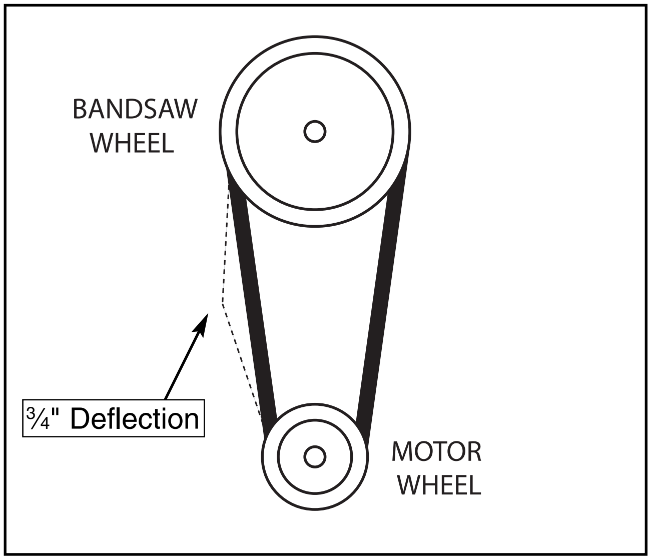


Figure 39. Correct V-belt deflection.

Blade Selection

NOTICE

Cutting with the bandsaw without correctly adjusting the tracking and tension may result in the blade falling off the wheels causing damage to the machine. Read and follow the directions in *Section 5: Set Up* after changing or adjusting the saw blade.

NOTICE

The Model G0513 uses 132" long blades. The Model G0514 uses 143" long blades.

A combination of factors must be considered when selecting the correct blade for a particular cutting operation.

BLADE WIDTH
The Model G0513 & G0514 can use blades from ⅛" to 1" in width. Blade width dictates the largest and smallest curve that can be cut, as well as how accurately it can cut a straight line.

- Curve Cutting — Use the chart in **Figure 40** to determine the correct blade for curve cutting. Determine the smallest radius curve that will be cut on your workpiece and use the corresponding width blade.

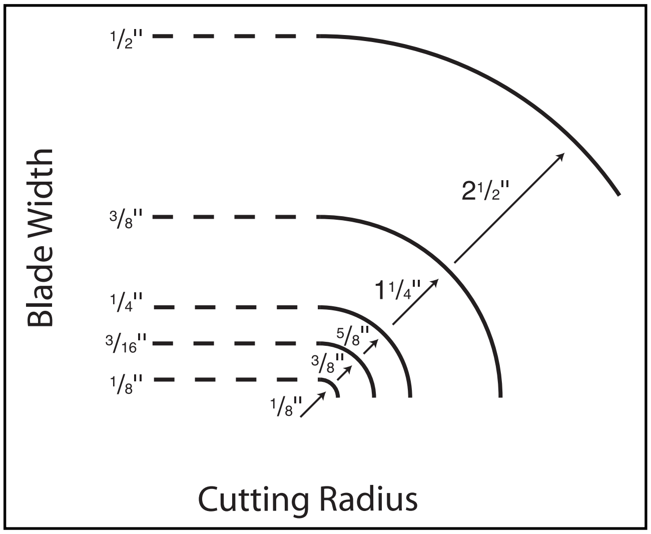


Figure 40. Determining correct blade width for cutting various curve sizes.

- Straight Cutting — Use the largest width blade that you own. The Model G0513 & G0514 will accept blades up to 1" wide.

TOOTH STYLE
Tooth shape, gullet size, and cut angle are all factors that determine the tooth style. **Figure 41** illustrates the three main categories of tooth style.

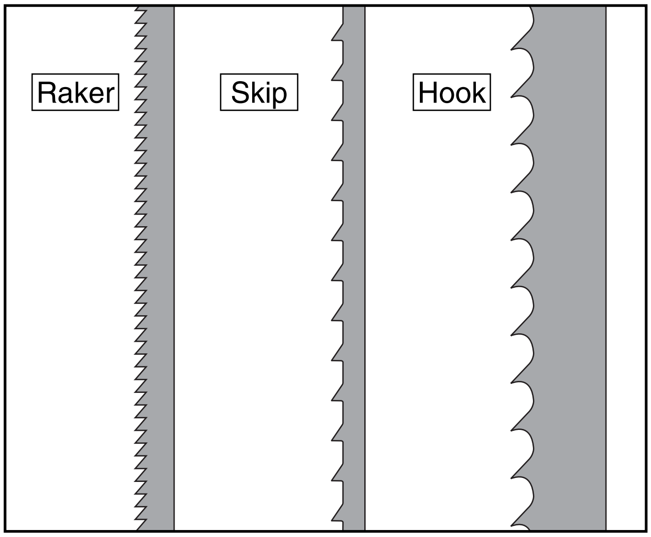


Figure 41. Raker, Skip & Hook tooth styles.

- Raker — A general purpose blade for straight and curve cutting of uniform materials.
- Skip — Shallow and flat gullets allow for fast material removal and reduce the tendency to clog. Skip tooth blades are ideal for cutting soft woods, gummy materials, and green lumber.
- Hook — Similar applications as the skip tooth blade, the hook tooth blade features a positive downward hook for faster, more aggressive cutting action.

TOOTH PITCH
Usually measured as TPI, tooth pitch refers to the number of teeth-per-inch. More teeth-per-inch (fine pitch) will cut slower, but will produce a smoother cut; while fewer teeth-per-inch (coarse pitch) will cut faster, but will produce a rougher cut.

As a general rule, choose blades that will have at least three teeth in the cut as shown in **Figure 42**. Fewer TPI are best for softer, wetter woods. Higher TPI are best for harder, drier woods.

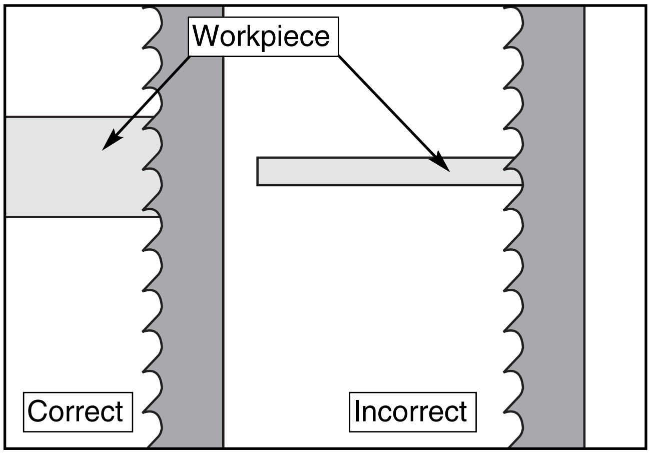


Figure 42. Determining correct tooth pitch for workpiece thickness.

BLADE BREAKAGE

Many factors can cause a blade to break. Breakage is often unavoidable because of the high levels of stress and strain applied to the blade. Avoidable breakage is usually the result of improper care or judgement on the part of the operator when mounting or adjusting the blade or support guides.

The most common causes of blade breakage are:

- Incorrect alignment and adjustment of the blade guides.
- Forcing or twisting a wide blade around a tight curve.
- Feeding the wood into the blade too fast.
- Using a dull blade.
- Excessive blade tension.
- Top blade guide assembly set too high above the workpiece.
- Using a blade with a braze or weld that is not smooth.

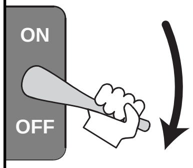
BLADE CARE

When taken care of correctly, bandsaw blades will provide a long usable life. When not handled, used, cleaned, or stored properly, they will quickly lose their ability to perform accurate and reliable cuts.

- Handling — Bandsaw blades may become damaged if they are not handled with care. Never leave the blade laying on the floor or table where it can be stepped on or where something can be set on it.
- Usage — Be sure to select blades with the proper width, style, and pitch for each application. Using the wrong blade will often produce excessive heat which can shorten the usable life of the blade.
- Cleaning — A clean blade will perform much better than a dirty blade. Dirty blades pass through the cutting material with more resistance than clean blades, causing excessive heat. Cleaners like OxiSolv® Blade & Bit Cleaner are available in the Grizzly catalog.
- Storage — A wall rack is the ideal location for storing blades.

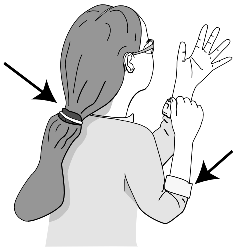
SECTION 7: MAINTENANCE

General



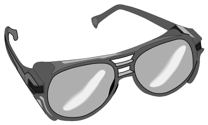
⚠WARNING

Disconnect power to the machine when performing any maintenance, assembly or adjustments. Failure to do this may result in serious personal injury.



⚠WARNING

Keep loose clothing rolled up and out of the way of machinery and keep hair pulled back.



⚠WARNING

Wear safety glasses during the entire maintenance process. Failure to comply may result in serious personal injury.

⚠WARNING

DO NOT attempt to investigate or adjust any features of the machine while it is running. Wait until the machine is turned off, unplugged and all working parts have come to a rest before you do anything!

Schedule

Check the following items before you use the bandsaw:

- Loose mounting bolts.
- Worn or damaged blade.
- Worn or damaged wires.
- Worn or damaged guide bearings.
- Any other condition that could hamper the safe operation of this machine.

Perform the following tasks at the scheduled time intervals:

After Each Use

- Wipe off the sawdust build-up from the table surface.
- With the blade removed, wipe off the sawdust build-up from the wheel tires and the wheel brush.
- Check the guide bearings for sawdust build-up. Clean if necessary.

Weekly

- Wipe a lubricant such as SLIPIT® onto the cast iron table.

Monthly

- Make sure the V-belt is correctly tensioned.

Long-Term Storage

- Keep unpainted surfaces rust free with products such as Boeshield® T-9.

Lubrication

Most of the bearings on this bandsaw are sealed and permanently lubricated and require no lubrication. The bearings are standard sizes and can be purchased from the Grizzly Parts Department when they need to be replaced.

The Oil Lite bearings require cleaning and relubricating after every 8 hours of continuous use.

To remove and clean the bearings:

1. **Unplug the bandsaw!**
2. Loosen the thumb screws in **Figure 43**.
3. Slide the Oil Lite bearings out of the blade guide assembly.
4. Clean the Oil Lite bearings with a solvent cleaner.
5. Apply a small amount of SAE 10wt oil to the inside surface of the Oil Lite bearings.
6. Reverse the above steps to re-assemble the guide bearings.

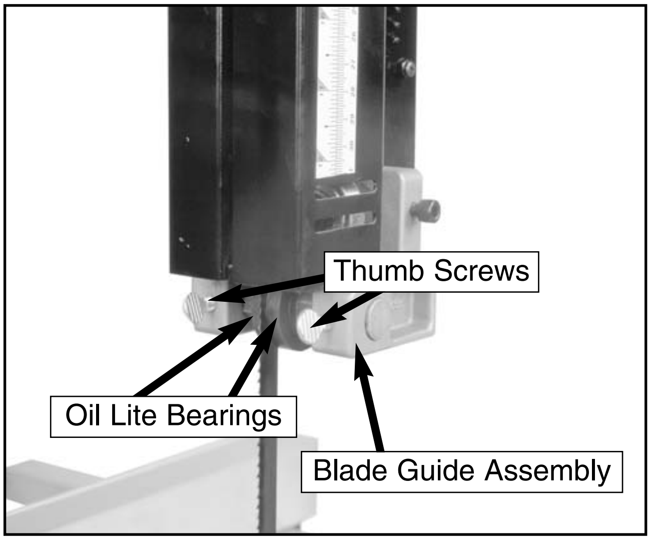


Figure 43. Front of upper blade guide.

* * *

Wheel Brush

The bandsaw is equipped with a lower wheel brush. The brush should be checked daily and cleaned when it becomes dirty. There is an adjustment bracket that allows the brush to be adjusted for bristle wear.

* * *

Table

The table is made from cast iron. If preventative measures are not taken, the table surface will rust. Wipe sawdust from the table to prevent rust causing moisture from becoming trapped against the table. Regular applications of products like SLIP-IT® will prevent rust as the saw is used on a daily basis. For long term storage, use products such as Boeshield T-9®. Both of these products are available in the Grizzly catalog.

* * *

SECTION 8: CLOSURE

The following pages contain general machine data, parts diagrams/lists, a troubleshooting guide and Warranty/Return information for the Model G0513 & G0514.

If you need parts or help in assembling your machine, or if you need operational information, we encourage you to call our Service Department. Our trained service technicians will be glad to help you.

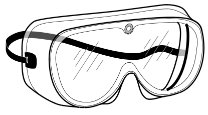
If you have any comments regarding this manual, please write to us at the address below:

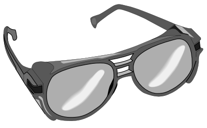
Grizzly Industrial, Inc.
c/o Technical Documentation
P.O. Box 2069
Bellingham, WA 98227-2069

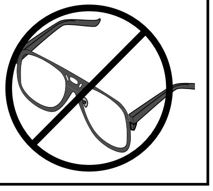
We have included some important safety measures that are essential to the operation of this machine. While most safety measures are generally universal, Grizzly reminds you that each workshop is different and safety rules should be considered as they apply to your specific situation.

⚠WARNING

Operating this equipment creates the potential for flying debris to cause eye injury. Always wear safety glasses or goggles when operating equipment. Everyday glasses or reading glasses only have impact resistant lenses, they are not safety glasses. Be certain the safety glasses you wear meet the appropriate standards of the American National Standards Institute (ANSI).







We recommend you keep a copy of our current catalog for complete information regarding Grizzly's warranty and return policy. If you need additional technical information relating to this machine, or if you need general assistance or replacement parts, please contact the service department at the location listed below.

Grizzly Industrial, Inc.
1203 Lycoming Circle
Muncy, PA 17756
Phone: (570) 546-9663
Fax: (800) 438-5901
E-Mail: techsupport@grizzly.com
Web Site: http://www.grizzly.com.

Additional information sources are necessary to realize the full potential of this machine. Trade journals, woodworking magazines, and your local library are good places to start.

⚠WARNING

The Model G0513 & G0514 are specifically designed for cutting operations. DO NOT MODIFY AND/OR USE THIS MACHINE FOR ANY OTHER PURPOSE. Modifications or improper use of this tool will void the warranty. If you are confused about any aspect of this machine, DO NOT use it until all your questions have been answered or serious personal injury may occur.

⚠WARNING

Like all power tools, there is danger associated with the Model G0513 & G0514. Accidents are frequently caused by lack of familiarity or failure to pay attention. Use this tool with respect and caution to lessen the possibility of operator injury. If normal safety precautions are overlooked or ignored, serious personal injury may occur.

MACHINE DATA SHEET

Customer Service #: (570) 546-9663 • To Order Call: (800) 523-4777 • Fax #: (800) 438-5901

MODEL G0513 17" HEAVY-DUTY BANDSAW

Design Type	Floor Model
Overall Dimensions:	
Table Size	17" x 17" x 1½"
Height From Floor To Table	37½"
Overall Height	73"
Overall Width	32"
Overall Depth	32"
Shipping Weight	321 lbs.
Machine Weight	266 lbs.
Crate Size	30"L x 20"W x 80"H
Footprint	27"W x 17¾"D
Capacities:	
Throat Capacity (Left of Blade)	16¼"
Height Capacity	12"
Table Tilt	10°L, 45°R
Blade Size Range	⅛"-1"
Standard Blade Length	131½"
Blade Speeds	1600, 3300 FPM
Construction:	
Table	Precision Ground Cast Iron
Wheels	Fully Balanced Cast Aluminum w/Polyurethane Tires
Rip Fence	Deluxe Extruded Aluminum Fence
Wheel Covers	Pre-Formed Steel
Guides	Roller Disc/Ball Bearing
Main Motor:	
Type	TEFC Capacitor-Start Induction
Horsepower	2 HP
Phase/Voltage	Single-Phase/110/220V
Amps	20/10A
Cycle/RPM	60 Hertz/1725 RPM
Bearings	Shielded & Permanently Lubricated Ball Bearings
Features:	
	4" Dust Port x 2
	Quick Change Blade Release/Tensioner
	Blade Tension Indicator
	Micro Adjusting Geared Table
	Height Scale Measurement
	Magnifying Window Over Fence Scale
	Hinged Wheel Covers

Specifications, while deemed accurate, are not guaranteed.

Grizzly Industrial, Inc.®

MACHINE DATA SHEET

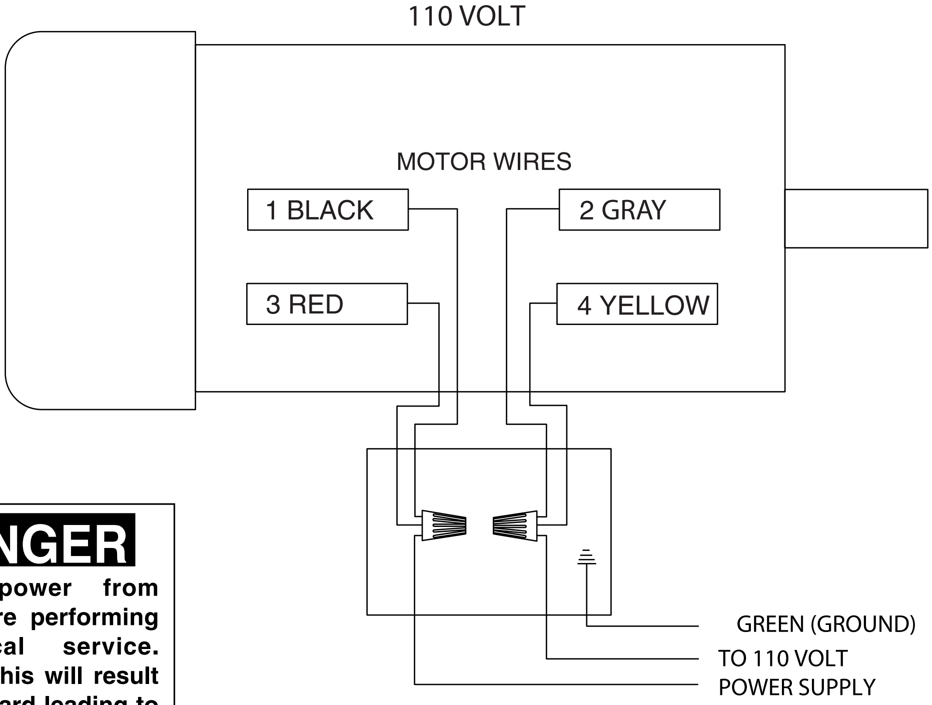
Customer Service #: (570) 546-9663 • To Order Call: (800) 523-4777 • Fax #: (800) 438-5901

MODEL G0514 19" HEAVY-DUTY BANDSAW

Design Type	Floor Model
Overall Dimensions:	
Table Size	19" x 19" x 1½"
Height From Floor To Table	37½"
Overall Height	78"
Overall Width	36"
Overall Depth (Including Fence)	32"
Shipping Weight	383 lbs.
Machine Weight	319 lbs.
Crate Size	34"L x 20"W x 85"H
Footprint	29½"W x 17¾"D
Capacities:	
Throat Capacity (Left of Blade)	18¼"
Height Capacity	12"
Table Tilt	10˚L, 45˚R
Blade Size Range	⅛"-1¼"
Standard Blade Length	143"
Blade Speeds	1700, 3500 FPM
Construction:	
Table	Precision Ground Cast Iron
Wheels	Fully Balanced Cast Aluminum w/Polyurethane Tires
Rip Fence	Deluxe Extruded Aluminum Fence
Wheel Covers	Pre-Formed Steel
Guides	Roller Disc/Ball Bearings
Main Motor:	
Type	TEFC Capacitor-Start Induction
Horsepower	2 HP
Phase/Voltage	Single-Phase / 110/220V
Amps	20/10A
Cycle/RPM	60 Hertz/1725 RPM
Bearings	Shielded & Permanently Lubricated Ball Bearings
Features:	
	4" Dust Port x 2
	Quick Change Blade Release/Tensioner
	Blade Tension Indicator
	Micro Adjusting Geared Table
	Height Scale Measurement
	Magnifying Window Over Fence Scale
	Hinged Wheel Covers

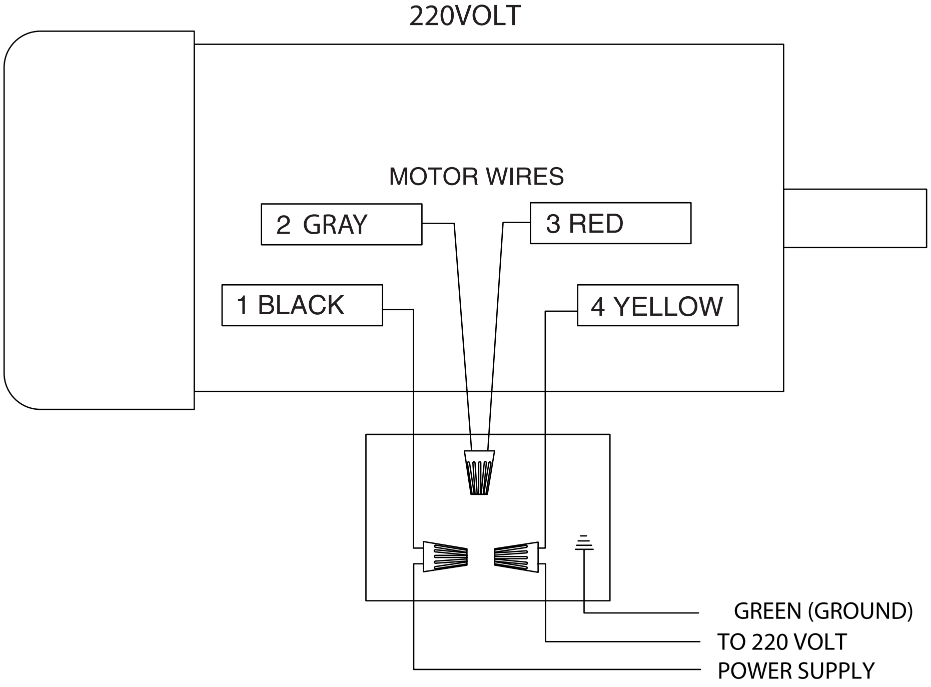
Specifications, while deemed accurate, are not guaranteed.

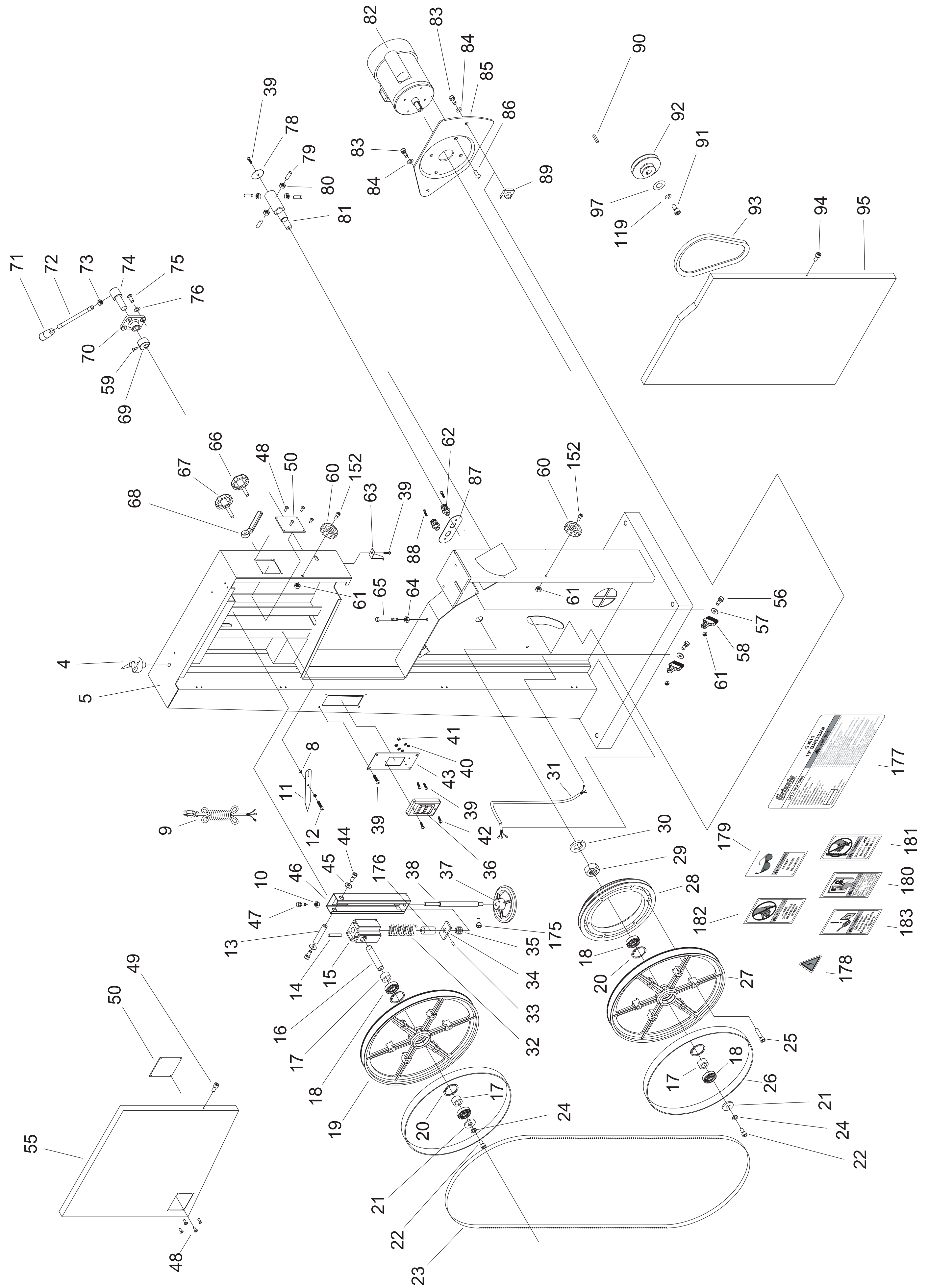
G0513/G0514
17" & 19" HEAVY-DUTY BANDSAWS

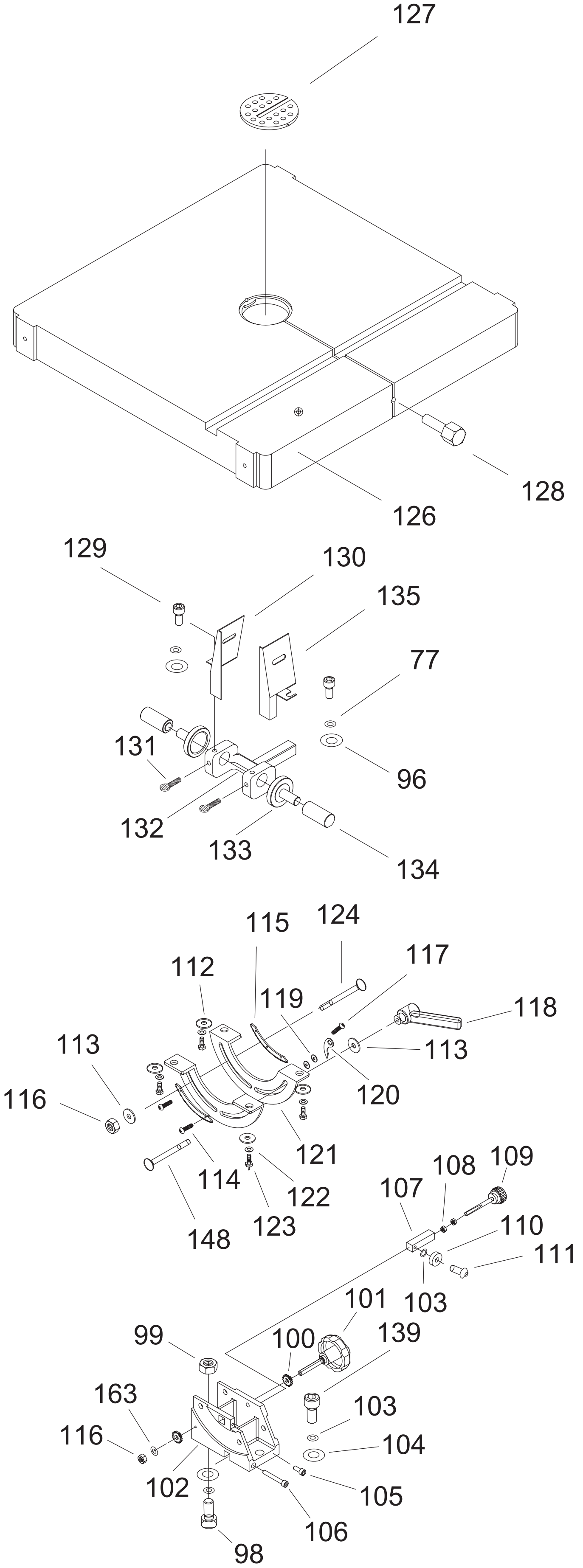


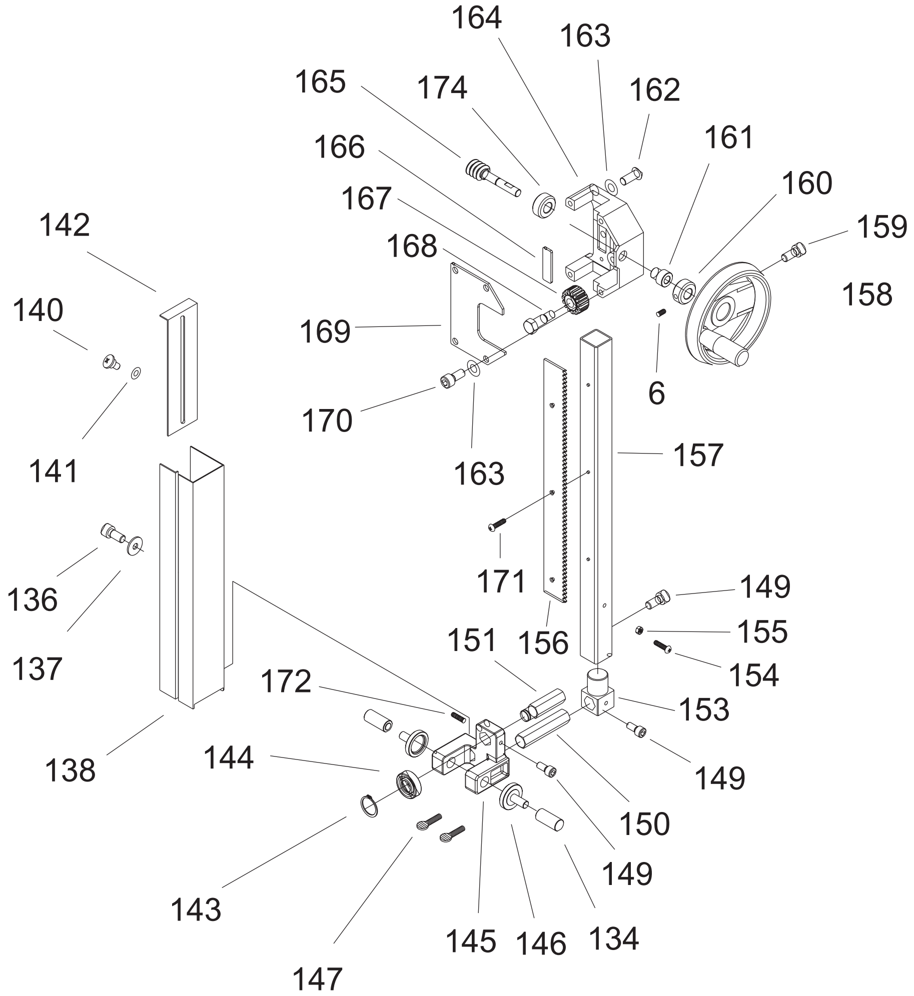
⚠DANGER

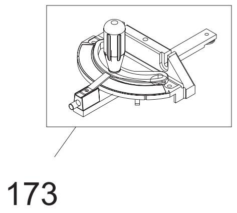
Disconnect power from machine before performing any electrical service. Failure to do this will result in a shock hazard leading to injury or death.







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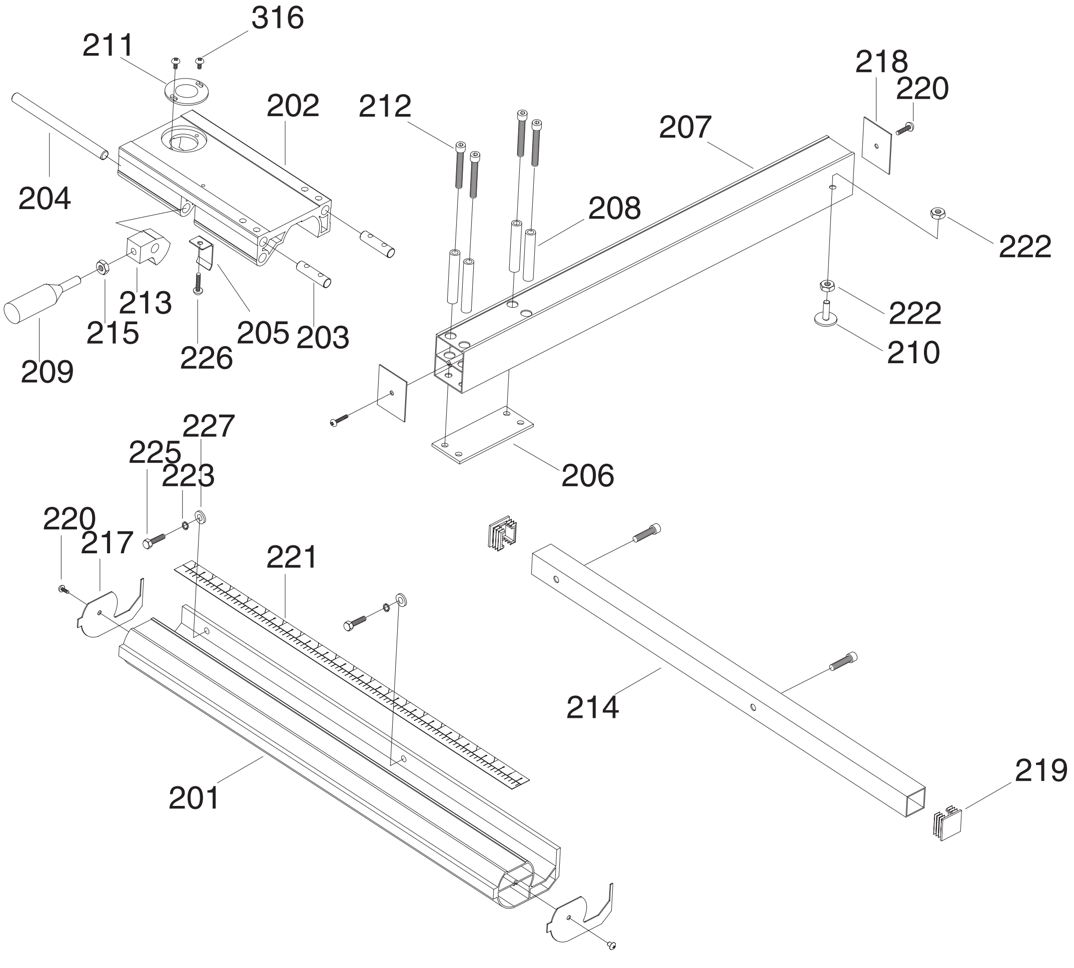

REF	PART #	DESCRIPTION
04	P0513004	RING
05	P0513005	MACHINE BODY
06	PSS07M	SET SCREW M5-0.8 X 5
08	PW03M	FLAT WASHER M6
09	PWRCRD220L	POWER CORD
10	PN01M	HEX NUT M6-1.0
11	P0513011	POINTER
12	P0513012	STEP SCREW
13	P0513013	UPPER SHAFT
14	PRP10M	ROLL PIN 5 X 36
15	P0513015	UPPER WHEEL SHAFT HINGE
16	P0513016	UPPER WHEEL SHAFT
17	P0513017	BUSHING
18	P6204	BEARING 6204
19	P0513019	UPPER WHEEL
20	PR25M	INT RETAINING RING M47
21	PW01M	FLAT WASHER M8
22	PB26M	HEX BOLT M8-1.25 X 30
23	P0513023	SAW BLADE 131.7" X 0.5"
24	PLW04M	LOCK WASHER M8
25	PB29M	HEX BOLT M6-1.0 X 30
26	P0513026	TIRE
27	P0513027	LOWER WHEEL
28	P0513028	IDLE PULLEY
29	P0513029	HEX NUT 1"-14
30	P0513030	LOCK WASHER 1"
31	P0513031	MOTOR CORD
32	P0513032	SPRING
33	PRP02M	ROLL PIN 3 X 16
34	P0513034	BLOCK
35	P0513035	BEARING 51201
36	P0513036	SWITCH
37	P0513037	HANDWHEEL
38	P0513038	ADJUSTING ROD
39	P0513039	PHLP HD SCR W/FLANGE M5-0.8 X 10
40	P0513040	STAR WASHER M5
41	PN06M	HEX NUT M5-0.8
42	P0513042	PHLP HD SCR W/FLANGE M5-0.8 X 16
43	P0513043	SWITCH PLATE
44	PB03M	HEX BOLT M8-1.25 X 16
45	PW01M	FLAT WASHER M8
46	P0513046	UPPER WHEEL SLIDINGBRACKET
47	PB10M	HEX BOLT M6-1.0 X 25
48	P013048	RIVET
49	PB04M	HEX BOLT M6-1.0 X 10
50	P0513050	CLEAR WINDOW
55	P0513055	UPPER WHEEL COVER
56	PB10M	HEX BOLT M6-1.0 X 25
57	PW03M	FLAT WASHER M6
58	P0513058	BRUSH
59	PB10M	HEX BOLT M6-1.0 X 25
60	P0513060	STAR HANDLE
61	P0513061	NYLON NUT M6-1.0

REF	PART #	DESCRIPTION
62	P0513062	STRAIN RELIEF
63	P0513063	POINTER
64	PN03M	HEX NUT M8-1.25
65	PB45M	HEX BOLT M8-1.25 X 100
66	P0513066	KNOB BOLT M10-1.5 X 20
67	P0513067	KNOB BOLT M10-1.5 X 53
68	P0513068	THREADED HANDLE M10-1.5
69	P0513069	CAM
70	P0513070	PILLOW BLOCK
71	P0513071	SHAFT END
72	P0513072	SHAFT
73	PN09M	HEX NUT M12-1.75
74	P0513074	SHAFT
75	PSB14M	CAP SCREW M8-1.25 X 20
76	PLW04M	LOCK WASHER M8
77	PLW03M	LOCK WASHER M6
78	P0513078	COVER
79	PSS09M	SET SCREW M8-1.25 X 20
80	PN03M	HEX NUT M8-1.25
81	P0513081	LOWER WHEEL SHAFT
82	P0513082	MOTOR 2HP
83	PB79M	HEX BOLT M10-1.5 X 25
84	PLW06M	LOCK WASHER M10
85	P0513085	MOTOR BRACKET
86	PSB14M	CAP SCREW M8-1.25 X 20
87	P0513087	PLATE
88	P0513088	PHLP HD SCR W/FLANGE M5-0.8 X 10
89	P0513089	PILLOW BLOCK
90	PK15M	KEY 5 X 5 X 35
91	P0513091	HEX BOLT M8-1.0 X 20 LH
92	P0513092	MOTOR PULLEY
93	P0513093	V-BELT A42
94	PB04M	HEX BOLT M6-1.0 X 10
95	P0513095	LOWER WHEEL COVER
96	PW03M	FLAT WASHER M6
97	PW01M	FLAT WASHER M8
98	PB14M	HEX BOLT M10-1.5 X 35
99	PN02M	HEX NUT M10-1.5
100	P0513100	SMALL GEAR
101	P0513101	STAR HANDLE
102	P0513102	TRUNNION SUPPORT BRACKET
103	PLW06M	LOCK WASHER M10
104	PW04M	FLAT WASHER M10
105	PB18M	HEX BOLT M6-1.0 X 15
106	PB39M	HEX BOLT M6-1.0 X 50
107	P0513107	PILLOW BLOCK
108	PN01M	HEX NUT M6-1.0
109	P0513109	ADJUSTMENT BOLT M6-1.0
110	P6000	BEARING 6000
111	PSB61M	CAP SCREW M10-1.5 X 20
112	PW01M	FLAT WASHER M8
113	PW01M	FLAT WASHER M8
114	PS17M	PHLP HD SCR M4-0.7 X 6

REF	PART #	DESCRIPTION
115	P0513115	GEAR PLATE
116	P0513116	NYLON NUT M8-1.25
117	PS17M	PHLP HD SCR M4-0.7 X 6
118	P0513118	LOCK HANDLE
119	PW05M	FLAT WASHER M4
120	P0513120	POINTER
121	P0513121	TRUNNION PLATE
122	PLW04M	LOCK WASHER M8
123	PB03M	HEX BOLT M8-1.25 X 16
124	PCB05M	CARRIAGE BOLT M8-1.25 X 80
126	P0513126	TABLE
127	P0513127	TABLE INSERT
128	P0513128	TABLE PIN
129	PB81M	HEX BOLT M6-1.0 X 6
130	P0513130	LEFT COVER
131	P0513131	THUMB SCREW
132	P0513132	LOWER BLADE GUIDE SUPPORT
133	P0513133	GUIDE RING
134	P0513134	LOWER ADJUST SHAFT
135	P0513135	RIGHT COVER
136	PB82M	HEX BOLT M5-0.8 X 10
137	PW02M	FLAT WASHER M5
138	P0513138	PROTECTIVE COVER
139	PB01M	HEX BOLT M10-1.5 X 30
140	P0513140	STEP SCREW
141	P0513141	FLAT WASHER
142	P0513142	SLIDING PLATE
143	P0513143	RETAINING RING S15
144	P6202	BEARING 6202
145	P0513145	UPPER BLADE GUIDE SUPPORT
146	P0513146	GUIDE RING
147	P0513147	THUMB SCREW M6-1.0 X 16
148	P0513148	CARRIAGE BOLT M8-1.25 X 85
149	PB18M	HEX BOLT M6-1.0 X 15
150	P0513150	ADJUST BAR
151	P0513151	UPPER SPACING SLEEVE
152	PB08M	HEX BOLT M6-1.0 X 20
153	P0513153	UPPER GUIDE SUPPORT BLOCK
154	PS38M	PHLP HD SCR M4-0.7 X 10
155	PN04M	HEX NUT M4-0.7
156	P0513156	RACK
157	P0513157	UPPER GUIDE HOSE
158	P0513158	HANDWHEEL
159	PB08M	HEX BOLT M6-1.0 X 20
160	P0513160	BUSHING
161	P0513161	BUSHING
162	PSB14M	CAP SCREW M8-1.25 X 20
163	P0513163	SPRING WASHER
164	P0513164	GUIDE BRACKET
165	P0513165	WORM CYLINDER
166	P0513166	FIXED PLATE
167	P0513167	GEAR
168	P0513168	FIXED BOLT

REF	PART #	DESCRIPTION
169	P0513169	COVER
170	PB03M	HEX BOLT M8-1.25 X 16
171	PS07M	PHLP M4-0.7 X 8
172	PSS11M	SET SCREW M6-1.0 X 16
173	P0513173	MITER GAUGE ASSY
173-1	P0513173-1	GUIDE BAR
173-2	P0513173-2	GUIDE
173-3	P0513173-3	POINTER
173-4	P0513173-4	NYLON WASHER ¼"
173-5	P0513173-5	HANDLE
173-6	P0513173-6	MITER GAUGE BODY
173-7	P0513173-7	SHAFT
173-8	PS37M	PHLP M6-1.0 X 6
173-9	P0513173-9	PHLP HED SCR W/ FLANGE M5-0.8 X 8
174	P0513174	BRUSH
175	PB08M	HEX BOLT M6-1.0 X 20
176	P0513176	BUSHING
177	P0513177	MACHINE WARNING/ID
178	P0513178	ELECTRICITY WARNING
179	P0513179	SAFETY GLASSES WARNING
180	P0513180	READ MANUAL WARNING
181	P0513181	BLADE TOUCH WARNING
182	P0513182	DOOR CLOSE WARNING
183	P0513183	UNPLUG WARNING
184	P0513184	CAST LOGO
201	P0513201	LARGE FENCE RAIL
202	P0513202	ADJUSTABLE BASE
203	P0513203	FIXED SHAFT
204	P0513204	SHAFT
205	P0513205	SPRING PIECE
206	P0513206	BRACKET
207	P0513207	SUPPORT TUBE
208	P0513208	INTERNAL SHEATH
209	P0513209	HANDLE
210	P0513210	ADJUSTABLE RUNNER
211	P0513211	CONVEX WINDOW
212	PSB83M	CAP SCREW M6-1.0 X 55
213	P0513213	LOCK MECHANISM
214	P0513214	REAR FENCE RAIL
215	PN03M	HEX NUT M8-1.25
216	PFS04M	FLANGE SCREW M4-0.7 X 6
217	P0513217	LARGE RAIL CAP
218	P0513218	FENCE CAP
219	P0513219	SMALL RAIL CAP
220	PHTEK3M	TAP SCREW M3.5 X 8
221	P0513221	SCALE
222	PN01M	HEX NUT M6-1.0
223	PLW03M	LOCK WASHER M6
224	PSB01M	CAP SCREW M6-1.0 X 16
225	PB08M	HEX BOLT M6-1.0 X 20
226	PFS05M	FLANGE SCREW M4-0.7 X 10
227	PW03M	FLAT WASHER M6

WARRANTY AND RETURNS

Grizzly Industrial, Inc. warrants every product it sells for a period of **1 year** to the original purchaser from the date of purchase. This warranty does not apply to defects due directly or indirectly to misuse, abuse, negligence, accidents, repairs or alterations or lack of maintenance. This is Grizzly's sole written warranty and any and all warranties that may be implied by law, including any merchantability or fitness, for any particular purpose, are hereby limited to the duration of this written warranty. We do not warrant or represent that the merchandise complies with the provisions of any law or acts unless the manufacturer so warrants. In no event shall Grizzly's liability under this warranty exceed the purchase price paid for the product and any legal actions brought against Grizzly shall be tried in the State of Washington, County of Whatcom.

We shall in no event be liable for death, injuries to persons or property or for incidental, contingent, special, or consequential damages arising from the use of our products.

To take advantage of this warranty, contact us by mail or phone and give us all the details. We will then issue you a "Return Number," which must be clearly posted on the outside as well as the inside of the carton. We will not accept any item back without this number. Proof of purchase must accompany the merchandise.

The manufacturers reserve the right to change specifications at any time because they constantly strive to achieve better quality equipment. We make every effort to ensure that our products meet high quality and durability standards and we hope you never need to use this warranty.

Please feel free to write or call us if you have any questions about the machine or the manual.

Thank you again for your business and continued support. We hope to serve you again soon.

WARRANTY CARD

Name ____
Street ____
City ____State________Zip_________
Phone Number________________________E-Mail________________________FAX__________________________
MODEL # Order #________________ Serial #________________________

The following information is given on a voluntary basis. It will be used for marketing purposes to help us develop better products and services. Of course, all information is strictly confidential.

1. How did you learn about us?

___Advertisement
___Catalog
___World Wide Web
___Friend
___Card Deck

___Other____

2. Which of the following magazines do you subscribe to.

___American Woodworker
___Cabinetmaker
___Family Handyman
___Fine Homebuilding
___Fine Woodworking
___Home Handyman
___Journal of Light Construction
___Old House Journal
___Popular Mechanics
___Popular Science
___Popular Woodworking
___Practical Homeowner
___Shop Notes
___Today's Homeowner
___WOOD
___Wooden Boat
___Woodshop News
___Woodsmith
___Woodwork
___Woodworker
___Woodworker's Journal
___Workbench

___Other____

3. Which of the following woodworking/remodeling shows do you watch?

___Backyard America
___Home Time
___The American Woodworker
___The New Yankee Workshop
___This Old House
___Woodwright's Shop

___Other____

4. What is your annual household income?

___$20,000-$29,999
___$30,000-$39,999
___$40,000-$49,999
___$50,000-$59,999
___$60,000-$69,999
___$70,000-$79,999
___$80,000-$89,999
___$90,000 +

5. What is your age group?

___20-29
___30-39
___40-49
___50-59
___60-69
___70 +

6. How long have you been a woodworker?

___0 - 2 Years
___2 - 8 Years
___8 - 20 Years
___20+ Years

7. How would you rank your woodworking skills?

___Simple
___Intermediate
___Advanced
___Master Craftsman

8. What stationary woodworking tools do you own? Check all that apply.

___Air Compressor
___Band Saw
___Drill Press
___Drum Sander
___Dust Collector
___Horizontal Boring Machine
___Jointer
___Lathe
___Mortiser
___Panel Saw
___Planer
___Power Feeder
___Radial Arm Saw
___Shaper
___Spindle Sander
___Table Saw
___Vacuum Veneer Press
___Wide Belt Sander

___Other____

9. How many of your woodworking machines are Grizzly? _____________

10. Which benchtop tools do you own? Check all that apply.

___1" x 42" Belt Sander
___5" - 8" Drill Press
___8" Table Saw
___8" - 10" Bandsaw
___Disc/Belt Sander
___Mini Jointer
___6" - 8" Grinder
___Mini Lathe
___10" - 12" Thickness Planer
___Scroll Saw
___Spindle/Belt Sander

___Other____

11. How many of the machines checked above are Grizzly? ____________

12. Which portable/hand held power tools do you own? Check all that apply.

___Belt Sander
___Biscuit Joiner
___Circular Saw
___Detail Sander
___Drill/Driver
___Miter Saw
___Orbital Sander
___Palm Sander
___Portable Planer
___Saber Saw
___Reciprocating Saw
___Router

___Other____

13. What machines/supplies would you like Grizzly Industrial to carry?

____

____

14. What new accessories would you like Grizzly Industrial to carry?

____

____

15. What other companies do you purchase your tools and supplies from?

____

____

16. Do you think your purchase represents good value?

___Yes
___No

17. Would you recommend Grizzly Industrial to a friend?

___Yes
___No

18. Would you allow us to use your name as a reference for Grizzly customers in your area? **Note: We never use names more than three times.**

___Yes
___No

19. Comments:____

____

____

____

____

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Stamp
Here

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P.O. BOX 2069
BELLINGHAM, WA 98227-2069

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